

A6 CFD1

A6 C

Svetsautomat

Automatic welding machine

Schweissautomat

Machine automatique de soudage

Bruksanvisning och reservdelsförteckning

Instruction manual and spare parts list

Betriebsanweisung und Ersatzteilverzeichnis

Manuel d'instructions et liste de pièces détachées

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UNDERHÅLL

Dagligen:

- Rengör svetsautomaten från svetspulver och andra föroreningar.
- Kontrollera att samtliga elledningar och slangar är hela och rätt anslutna.
- Kontrollera att samtliga skruvförband är väl åtdragna.
- Kontrollera att pulvertransportörens gummiband är oskadade.

Periodiskt:

- Kontrollera elektrodmotorns kolborstar, byt när de är nedslitna till 6 mm.
- Kontrollera sliderna, smörj om de kärvar.
- Kontrollera elektrodmatarenhetens elektrodstyrning, drivrullar och kontaktmunstycke. Byt om de är slitna eller skadade.

TECHNICAL DESCRIPTION

TECHNICAL DESCRIPTION

The A6 CFD1 automatic welding machine is intended for submerged arc welding of horizontal joints on large tanks and cisterns. It consists of a modified A6 SFD1 automatic welding machine (see instructions no. 333 534-002) mounted on a carriage.

The carriage, which supports the operator and the welding equipment, runs along the upper edge of the plate to be welded. This means that the tops of plates forming the same lap of the tank must be at the same height, although minor differences in height can be accommodated during welding by use of the cross-slides on the welding machine.

Welding normally uses 2 x 2.0 mm or 2 x 2.5 mm filler wire, although use of a single wire is also possible.

The A6 CFD1 welding machine is available in left-handed and right-handed versions. Both versions are needed for simultaneous internal and external welding of the same tank on page 16.

| | |
|------------------------|---|
| Order number Nummer | A6 CFD1 automatic welding machine |
| 334 593-880 | Right-handed automatic tank welding machine |
| 334 593-881 | Left-handed automatic tank welding machine |

The operator controls the machine from a working platform on the carriage, from where all travel and welding operations and settings can be controlled using a standard PEG1 control unit.

Technical data:

| Welding machine | A6 C |
|--|----------------------------|
| Control and operating voltage | 42V DC |
| Travel speed, maximum | 250 cm/min |
| Welding speed, maximum | 250 cm/min |
| Wire feed speed, maximum | 8 m/min |
| Wire diameter | 2x2.0 mm och 2x2,5 mm |
| Tank | |
| Diameter for internal and external welding | min 5 m |
| Plate thickness | min 8 mm max 35 mm |
| Plate height | min 1900 mm max 3100 mm |

TECHNICAL DESCRIPTION

| Welding machine | A6 C |
|--|--------|
| Weights: | |
| Complete unit, ready to operate | 765 kg |
| Welding machine | 470 kg |
| Flux | 15 kg |
| Filler wire | 60 kg |
| Flux (2 spare sacks) | 50 kg |
| Filler wire (2 spare coils) | 60 kg |
| Tools | 10 kg |
| Max. load, including operator (for safety factor = 10) | 300 kg |

The A6 CFD1 automatic welding machine consists of:

- 1 A6 welding head, in left-handed or right-handed version.
The welding head is secured directly to the carriage, and follows the joint without being affected by movement of the operator's working platform. See instructions and spare parts list, order no. 333 534-002.
- 2 D35 twin contact equipment
for twin-wire welding
- 3 Filler wire drum (maximum wire weight, 30 kg)
- 4 Flux hopper
- 5 Flux conveyer
- 6 Flux suction unit
- 7 PEG1 control unit
for controlling welding and adjusting welding parameters. See instructions and spare parts list, order no. 333 470-001.
- 8 Emergency stop pushbutton
for emergency stop of both travel and welding.
- 9 Flame cleaning torch
- 10 Filter regulator (extra accessory), for water separation.
- 11 Lifting device for the welding head (extra accessory).
- 12 Operator's platform
The platform is of aluminium, supported by two adjustable scaffold clamps, one at each end of the upper beam of the carriage.
Two guide wheels are fixed to the platform, secured directly beneath the guide wheel and travel wheel respectively of the carriage. The carriage and platform can swing freely relative to each other in the radial direction of the tank. The amount of movement is limited by a strap, secured to the lower part of the carriage beam and the lifting eye of the clamp.
A canopy/screen of heavy-duty plastic-coated woven fabric surrounds the operator's platform and welding machine, providing protection against wind and the elements. It has three windows and an opening in the top for access of a crane hook to the lifting eye.

TECHNICAL DESCRIPTION

13 Ladder

Carriage

14 Carriage, left-handed or right-handed

The carriage is supported at three points. The first two support points consist of a guide wheel and a driving wheel running on the upper edge of the plate to be welded. These wheels are mounted on the upper horizontal beam of the carriage, and can be adjusted to suit the radius of the tank.

The third support point consists of a rubber caterpillar bogey, which also serves as a flux conveyor. It runs a few mm below the weld, and can be adjusted to the exact position as required.

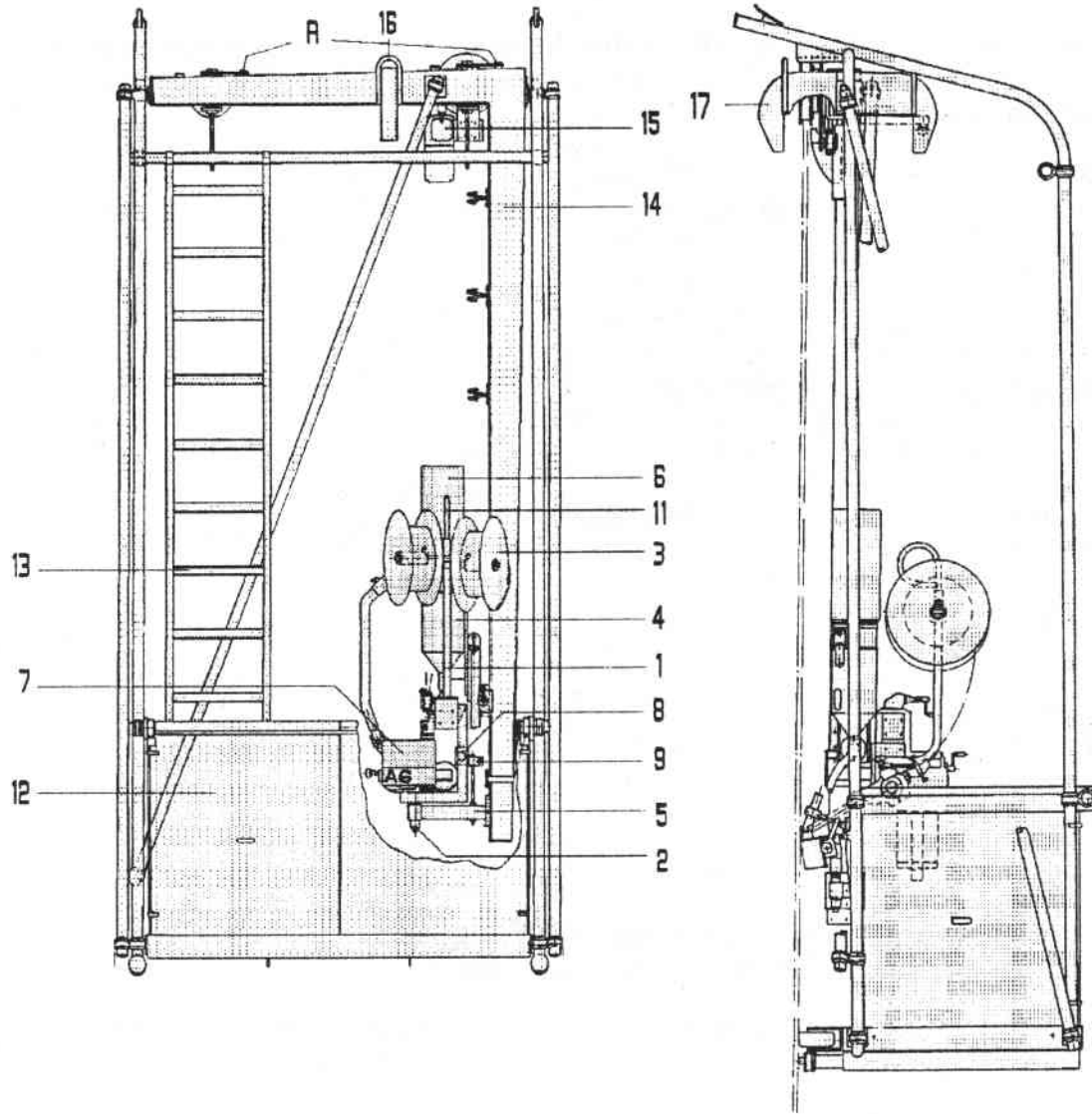
15 A6 VEC drive motor and gear unit (see instructions no. 333 533-003).

| | |
|----------------------|------------|
| Operating voltage | 42 V DC |
| Motor speed | 2000 r/min |
| Reduction gear ratio | 156:1 |

16 Lifting eye
for lifting the entire unit

17 Drop guard
Prevents the unit from falling to the ground if the wheels running along the top of the plate should be derailed.

TECHNICAL DESCRIPTION

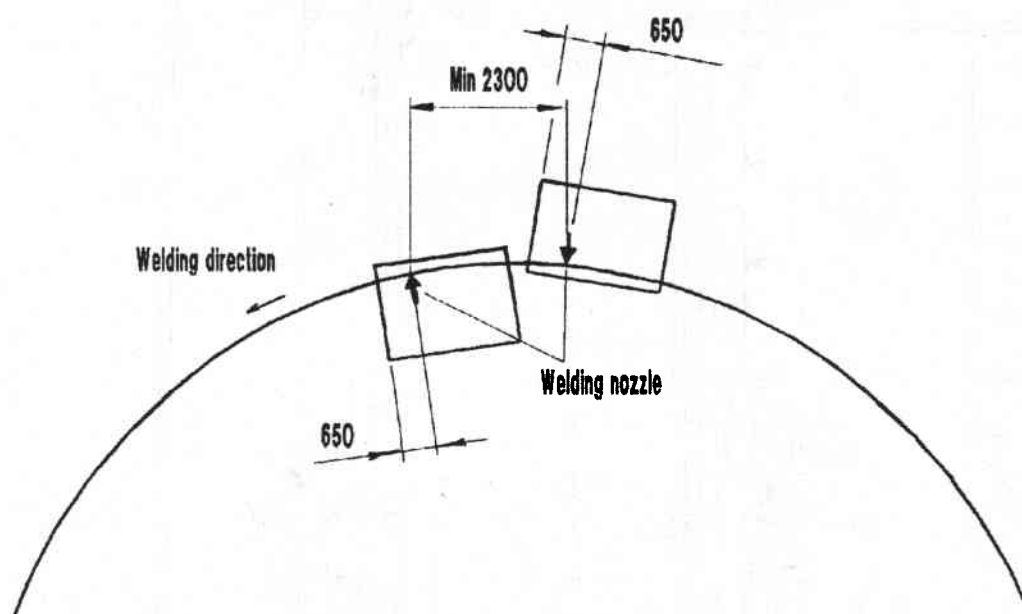


NOA1DP03

TECHNICAL DESCRIPTION

Internal and external tank welding

A right-handed and a left-handed unit should be ordered for internal and external welding of tanks. (It is also possible to convert one unit if two similarly-handed units are already owned.)



NOA1dp05

Standard arrangement for tank welding:

- One left-handed welding unit for internal welding.
- One right-handed welding unit for external welding.

This arrangement allows the operator to monitor welding performance, and to remove any slag products.

Extra accessories

| Order number | Extra accessories |
|--------------|--|
| 190 318-103 | Air hose (ordered in required lengths) |
| 2529 004-02 | Two hose clips |
| 153 337-880 | Filter regulator, for water separation |
| 334 058-880 | Lifting device for welding head |

INSTALLATION

1. Dimension drawing, see DIMENSION DRAWING on page 39.
2. A6 SFD1 automatic welding machine: see instructions no. 333 534-002.
3. A6 VEC geared motor unit: see instructions no. 333 533-003.
4. PEG1 control unit: see instructions no. 333 470-001.
5. Assemble the A6 CFD1 automatic tank welding machine as follows:
 - Support the carriage (14), consisting of the angle beam with drive unit and guide wheels, on a suitable support about 0.7 m above floor level, with the horizontal part of the beam on the support and the vertical beam resting on the floor.
 - Fit the operator's platform (12) by securing the outer tubular frame by means of scaffold clips to the upper part of the angled beam.
 - Lift the carriage up on to the workpiece.
 - Fit the welding unit (1).
 - Fit the flux conveyor (5).

Note that the welding machine and flux conveyor must be fitted in their correct positions on the vertical beam as required to suit the position of the welded joint.

 - Fit the enclosing canopy/screen.
Secure the upper part of the canopy to the projecting part of the platform framework.
 - Adjust the automatic drive equipment and the guide and support wheels to support the radius of the tank.
 - Slacken or tighten (as required) all locking and clamping bolts etc. when adjustments have been completed, on page 15.

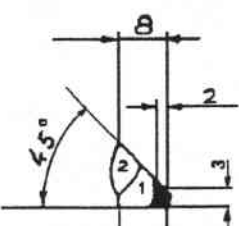
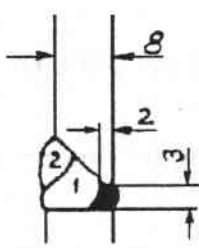
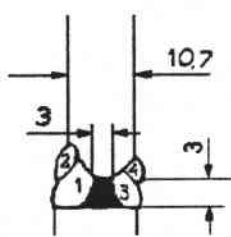
OPERATION

OPERATION

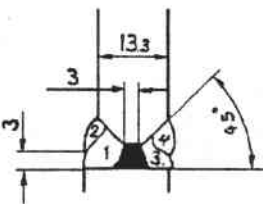
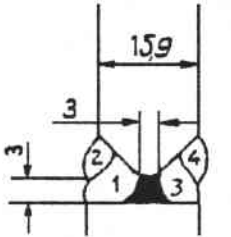
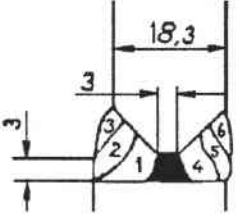
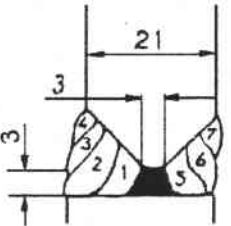
1. A6 SFD1 automatic welding machine: see instructions no. 333 534-002.
2. A6 VEC geared motor unit: see instructions no. 333 533-003.
3. PEG1 control unit: see instructions no. 333 470-001.
4. **Note** that the lifting device (extra accessory) must not be in position on the unit while welding is in progress in order to maintain the necessary electrical insulation.

Welding table

Welding table with manually-welded root weld:

| | Item | 1 | 2 | 3 | 4 | 5 | 6 | 7 |
|---|-----------|------|------|------|------|---|---|---|
| Fig. 1  | Electrode | 2xø2 | 1xø2 | | | | | |
| | Volt | 29 | 29 | | | | | |
| | Amp | 380 | 300 | | | | | |
| | m/h | 35 | 55 | | | | | |
| | | | | | | | | |
| Fig. 2  | Electrode | 2xø2 | 1xø2 | | | | | |
| | Volt | 29 | 29 | | | | | |
| | Amp | 400 | 300 | | | | | |
| | m/h | 35 | 55 | | | | | |
| | | | | | | | | |
| Fig. 3  | Electrode | 2xø2 | 1xø2 | 2xø2 | 1xø2 | | | |
| | Volt | 29 | 29 | 29 | 29 | | | |
| | Amp | 380 | 300 | 380 | 450 | | | |
| | m/h | 35 | 50 | 45 | 50 | | | |
| | | | | | | | | |

OPERATION

| | Item | 1 | 2 | 3 | 4 | 5 | 6 | 7 |
|--|-----------|------|------|------|------|------|------|------|
| Fig. 4  | Electrode | 2xØ2 | 1xØ2 | 2xØ2 | 1xØ2 | | | |
| | Volt | 29 | 29 | 29 | 29 | | | |
| | Amp | 400 | 325 | 400 | 300 | | | |
| | m/h | 35 | 47 | 45 | 50 | | | |
| Fig. 5  | Electrode | 2xØ2 | 1xØ2 | 2xØ2 | 1xØ2 | | | |
| | Volt | 29 | 28 | 29 | 28 | | | |
| | Amp | 525 | 350 | 500 | 350 | | | |
| | m/h | 30 | 43 | 40 | 47 | | | |
| Fig. 6  | Electrode | 2xØ2 | 2xØ2 | 1xØ2 | 2xØ2 | 2xØ2 | 1xØ2 | |
| | Volt | 30 | 28 | 28 | 30 | 28 | 28 | |
| | Amp | 550 | 500 | 350 | 550 | 475 | 350 | |
| | m/h | 27 | 32 | 43 | 27 | 40 | 45 | |
| Fig. 7  | Electrode | 2xØ2 | 2xØ2 | 2xØ2 | 1xØ2 | 2xØ2 | 2xØ2 | 2xØ2 |
| | Volt | 30 | 28 | 28 | 28 | 30 | 28 | 28 |
| | Amp | 600 | 550 | 425 | 350 | 575 | 500 | 375 |
| | m/h | 25 | 28 | 35 | 45 | 25 | 30 | 40 |

MAINTENANCE

MAINTENANCE

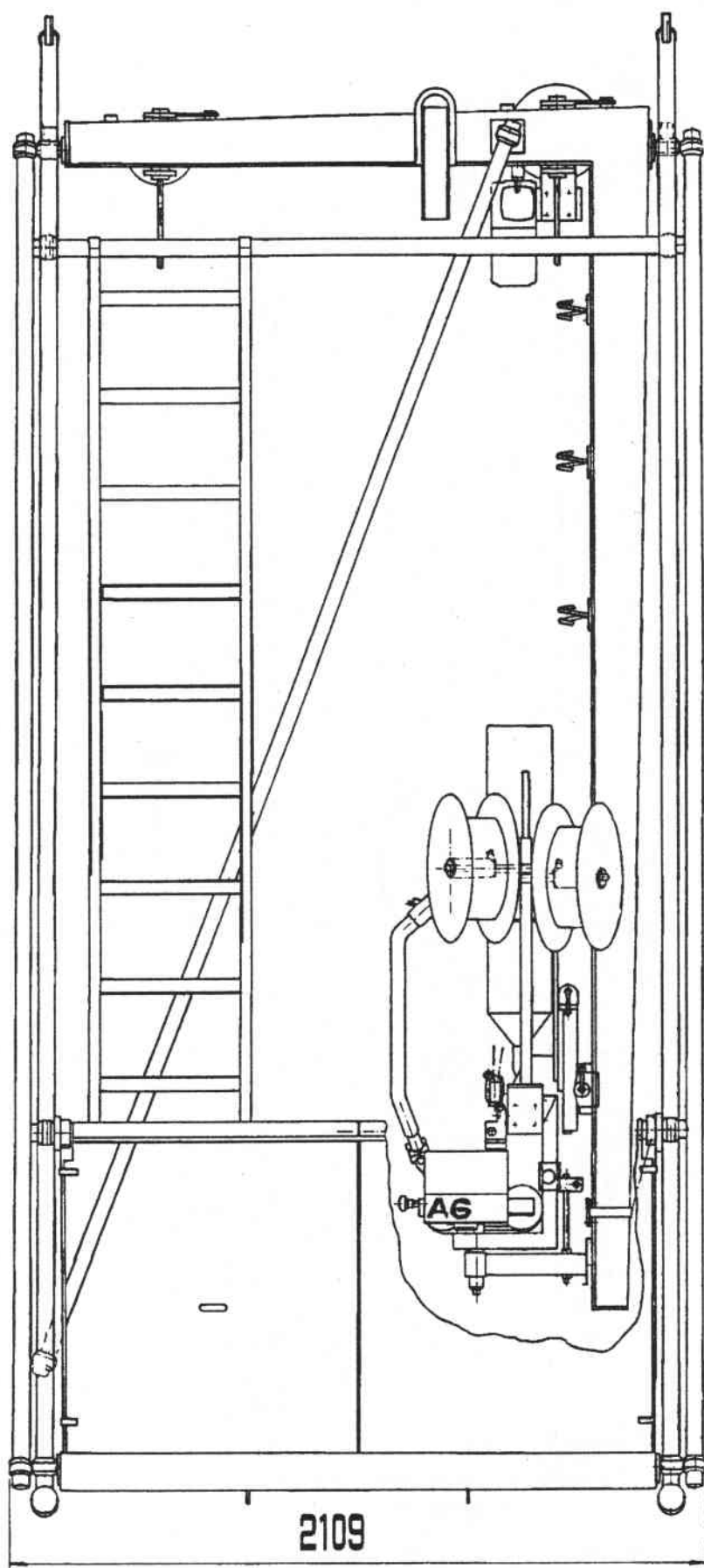
Daily:

- Remove flux and other foreign matter from the machine.
- Check that all hoses, wires and cables are undamaged and correctly connected.
- Check that all bolted joints are properly tightened.
- Check that the rubber caterpillar track of the flux conveyor is undamaged.

Periodic:

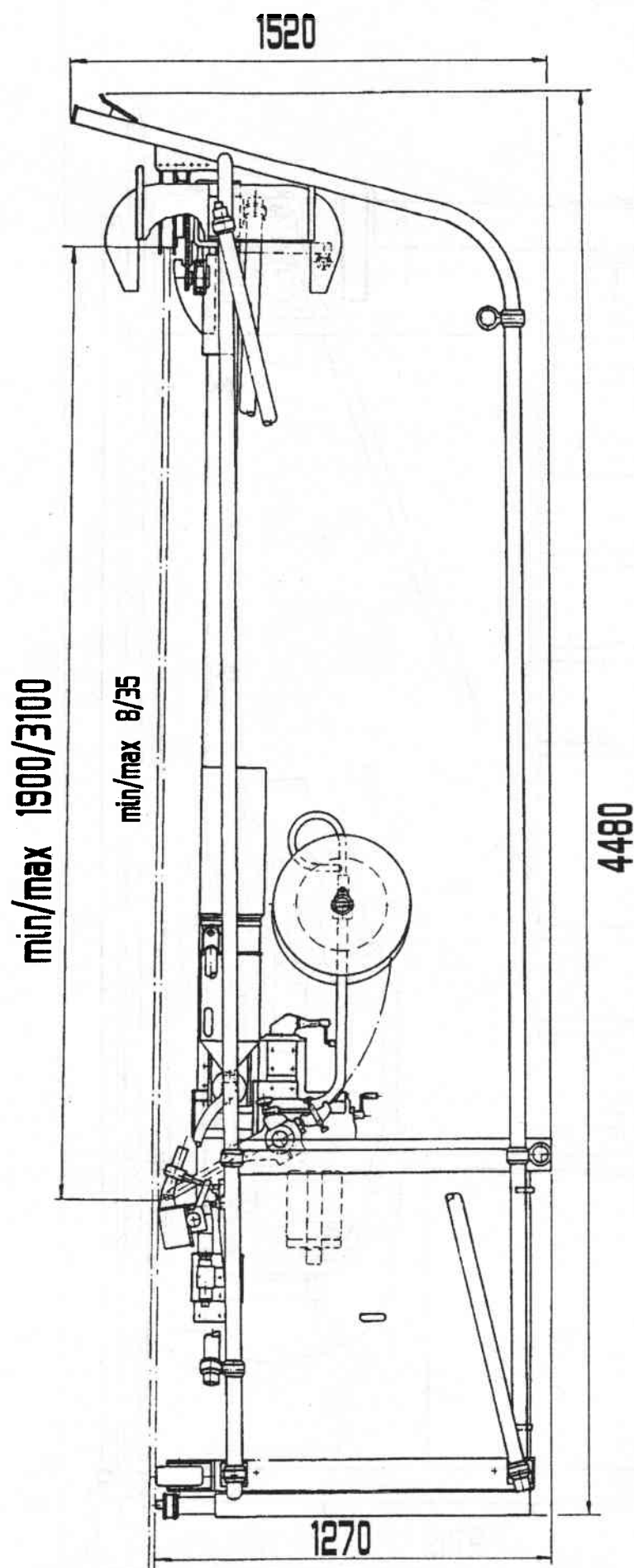
- Check the carbon brushes of the filler wire feed unit motor, and replace when they are worn down to 6 mm.
- Check the cross-slides, and lubricate if necessary.
- Check the wire feed guide, drive rollers and contact nozzle of the wire feed unit, and replace if worn or damaged.

Måttskiss - Dimension drawing - Massbild - Cotes d'encombrement
A6 CFD1



noa1mp01

Måttskiss - Dimension drawing - Massbild - Cotes d'encombrement
A6 CFD1



noa1mp02

Reservdelsförteckning

Spare parts list

Ersatzteilverzeichnis

Liste de pièces détachées

Reservdelar beställs genom närmaste ESAB-representant, se sista sidan. Vid beställning v.v. uppgi typ och tillverkningsnummer samt benämningar och beställningsnummer enligt reservdelsförteckningen.

Spare parts are to be ordered through the nearest ESAB agency as per the list on the back of the cover. Kindly indicate type of unit, serial number, denominations, and ordering numbers acc. to the spare parts list

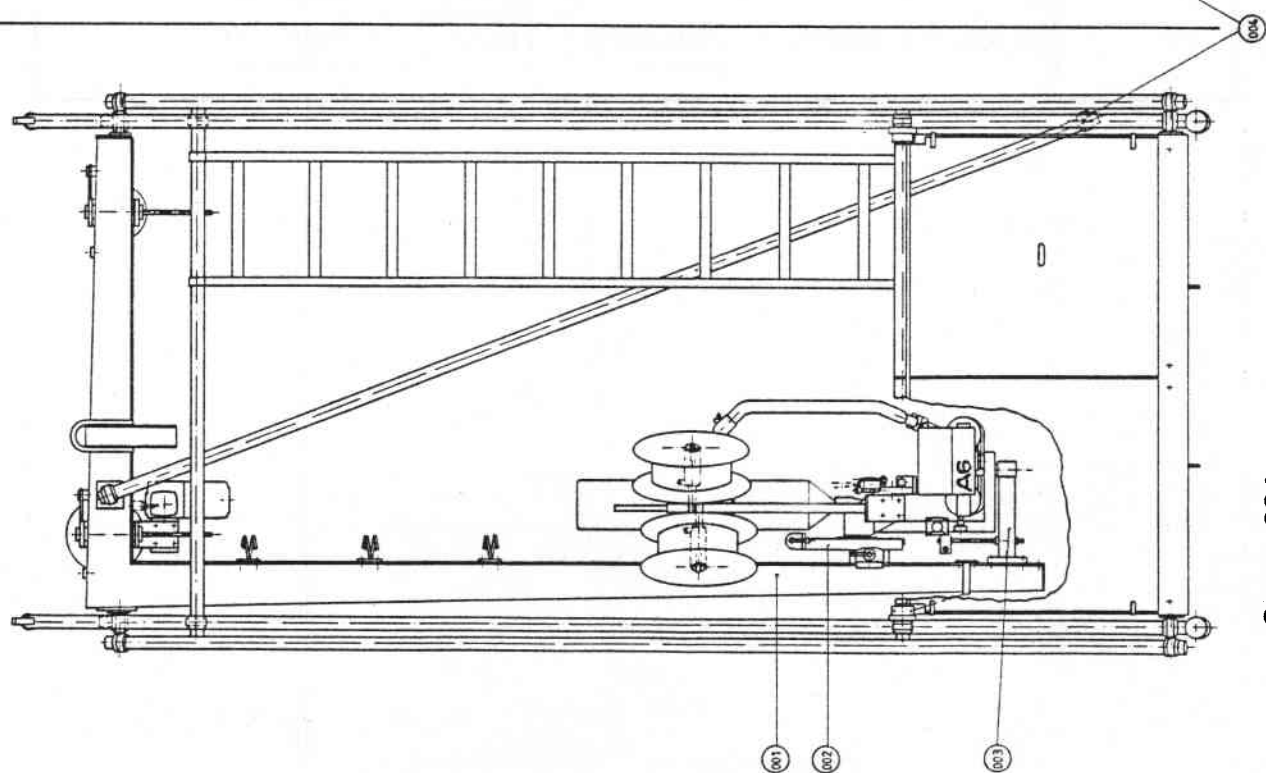
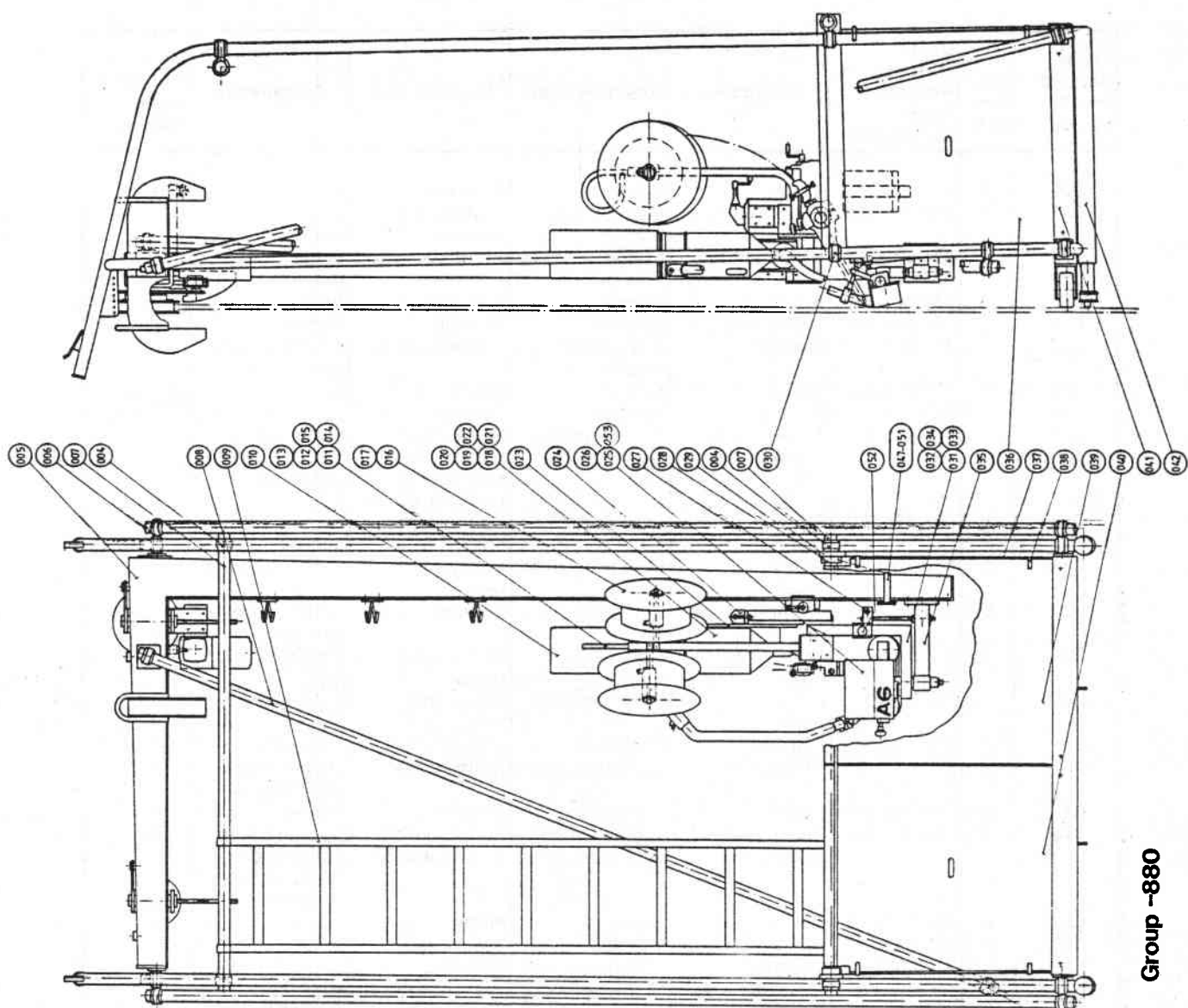
Die Ersatzteile können bei der nächsten ESAB-Vertretung bestellt werden, siehe letzte Seite. Bitte geben Sie Typenbezeichnung und Herstellnummer sowie Bezeichnungen und Bestellnummern lt. Ersatzteilverzeichnis an.

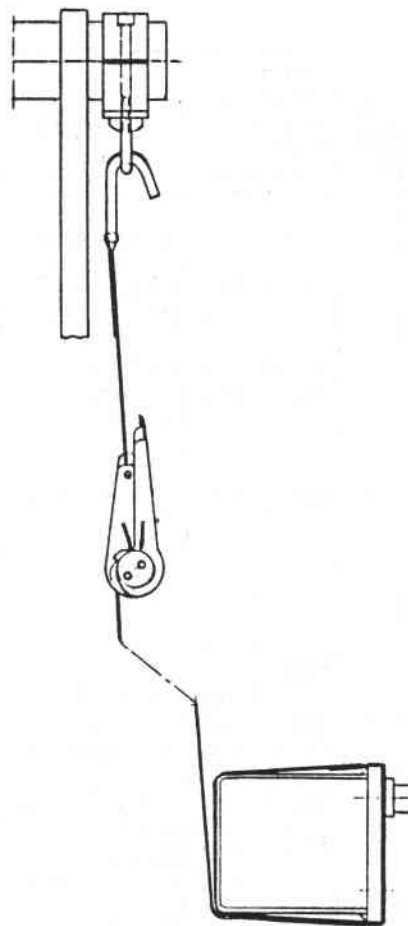
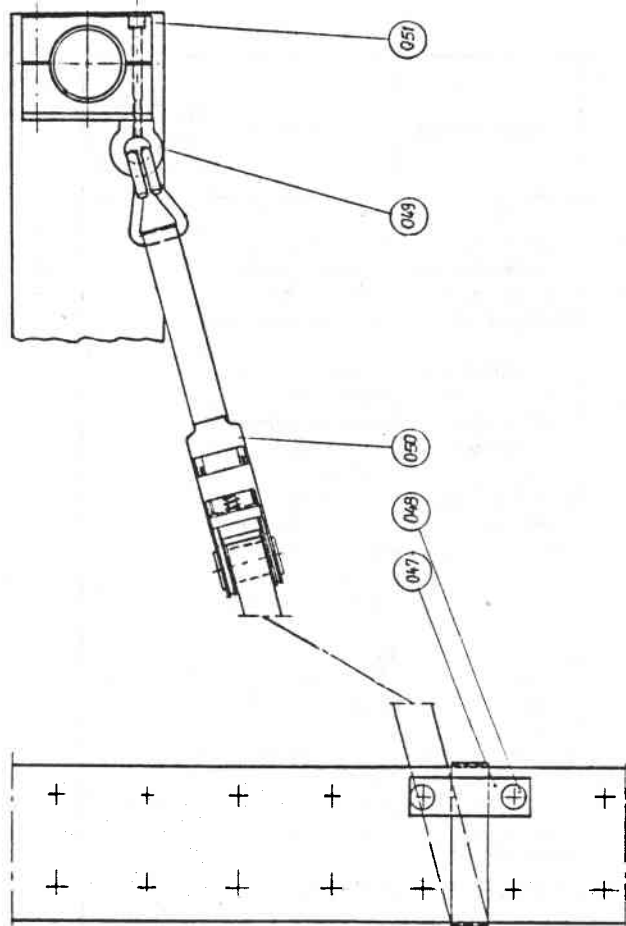
Au dos de la brochure, vous trouverez l'adresse du représentant ESAB le plus proche. Prière du lui adresser votre commande, après avoir pris le soin de mentionner le type et le numéro de série de l'unité ainsi que le numéro de commande et la désignation conformément à la liste de pièces détachées.

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|----------------------------------|---|--|---|------------------------------------|
| | | 334 593-880 | Cisternsvet-sautomat högerutf. | Tant welding automatic, right-hand design | Zisternenschweissautomat, rechtsausführung | Machine automatique de soudage de récipients, conception droite | |
| | | 334 593-881 | Cisternsvet-sautomat vänsterutf. | Tant welding automatic, left-hand design | Zisternenschweissautomat, linksausführung | Machine automatique de soudage de récipients, conception gauche | |
| 001 | 1 | 334 594-881 | Åkvagn, vänsterutf. | Carriage, left-hand design | Fahrwerk, links-ausführung | Chariot, conception gauche | |
| 002 | 1 | 334 660-881 | Svetshuvud vänsterutf. | Welding head, left-hand design | Schweisskopf, linksausführung | Tête de soudage, conception gauche | |
| 003 | 1 | 145 145-881 | Pulvertransportör, vänsterutf. | Flux conveyor, left-hand design | Schweisspulver Transporteur, linksausführung | Transporteur de flux, conception gauche | |
| 004 | 5 | 153 756-882 | Klamma | Clamp | Klemme | Bride | |
| 005 | 1 | 334 594-880 | Åkvagn högerutf. | Carriage, right-hand design | Fahrwerk, rechts-ausführung | Chariot, conception gauche | |
| 006 | 2 | 145 125-005 | Förbindningsrör | Stay tube | Strebe | Entretoisement | |
| 007 | 2 | 145 125-001 | Förbindningsrör | Stay tube | Strebe | Entretoisement | |
| 008 | 1 | 145 125-004 | Förbindningsrör | Stay tube | Strebe | Entretoisement | |
| 009 | 1 | 145 398-880 | Steg | Ladder | Leiter | Echelle | |
| 010 | 1 | 148 140-883 | Pulversugare | Flux recovery unit | Pulverabsauger | Aspirateur de flux | |
| 011 | 2 | 2126 011-10 | Mutter | Nut | Mutter | Ecrou | M10 |
| 012 | 4 | 2151 000-23 | Bricka | Washer | Scheibe | Rondelle | D22/10,5x2 |
| 013 | 2 | 2121 016-10 | Skruv | Screw | Schraube | Vis | M10x50 |
| 014 | 1 | 153 747-001 | Lyftögla | Lifting eye bolt | Hebeöse | Oeillet de levage | |
| 015 | 1 | 147 328-881 | Trumhållare | Reel holder | Drahttrommelhalter | Porte-bobine | |
| 016 | 2 | 153 872-880 | Elektrodrumma | Wire reel | Drahttrommel | Bobine | |
| 017 | 2 | 146 967-880 | Bromsnav | Brake hub | Bremsennabe | Moyeu-frein | |
| 018 | 1 | 147 649-880 | Pulverbehållare | Flux hopper | Pulverbehälter | Réservoir à flux | |
| 019 | 1 | 0203 017-80 | Pulversil | Flux strainer | Pulversieb | Filtre à flux | |
| 020 | 1 | 153 491-001 | Förgreningsrör | Manifold pipe | Abzweigrohr | Tube d'embranchement | |
| 021 | 1 | 2529 004-07 | Slangklämma | Hose clamp | Schlauchklemme | Collier de serrage | |
| 022 | 2 | 145 064-001 | Pulverslang | Flux hose | Pulverschlauch | Tuyau d'amenée de flux | D1", L = 630 |
| 023 | 1 | 148 487-881 | Hållare | Holder | Halterung | Support | |
| 024 | 1 | 334 660-880 | Svetshuvud högerutf. | Welding head | Schweisskopf | Tête de soudage | |
| 025 | 1 | 333 001-912 | Manöverlåda | Control box | Bedienungskasten | Coffret de commande | PEG 1 |

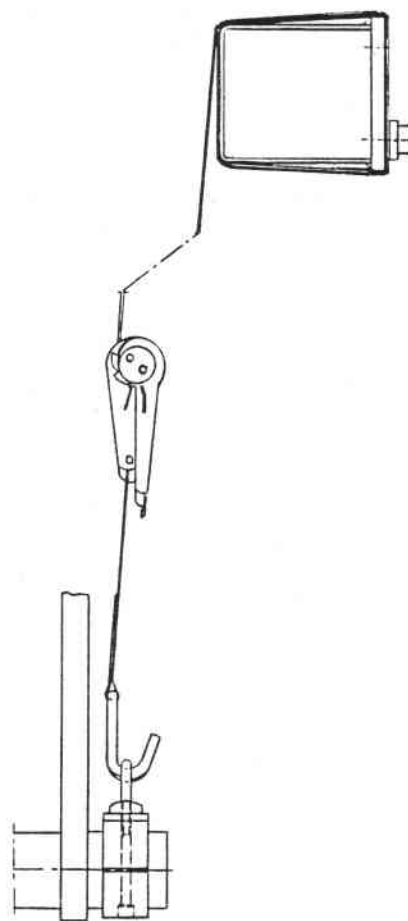
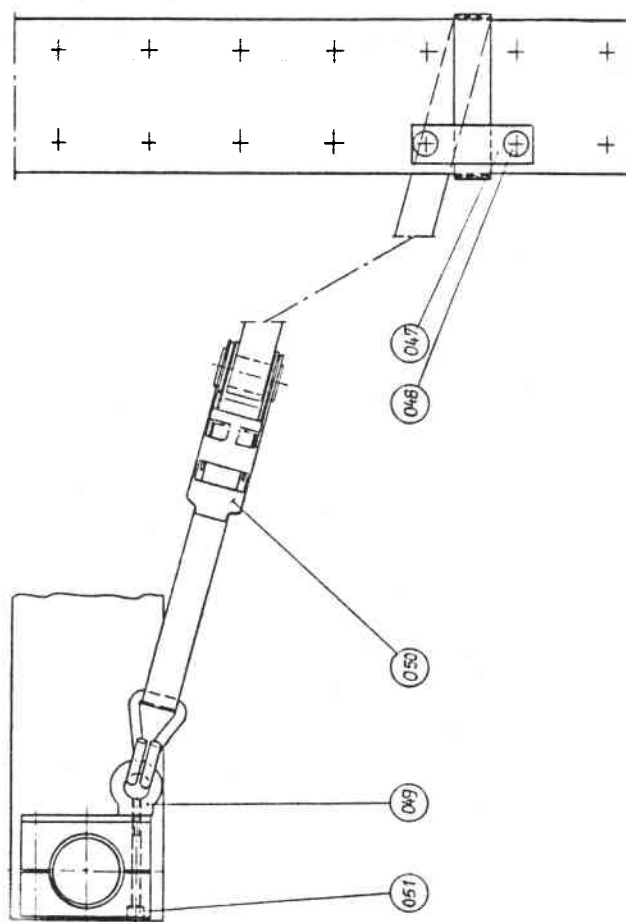
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|---|--|--|--|---|------------------------------------|
| 026 | 4 | 2121 107-17 | Skruv | Screw | Schraube | Vis | B8x9,5 |
| 027 | 1 | 153 179-880 | Flamrensbrän- nare | Flame-clean burner | Reinigungs- brenner | Brûleur de nettoyage | |
| 028 | 2 | 334 729-880 | Klämma | Clamp | Klemme | Bride | |
| 029 | 2 | 334 702-880 | Bom | Boom | Schranke | Barre | |
| 030 | 2 | 334 669-880 | Klämma | Clamp | Klemme | Bride | |
| 031 | 1 | 153 746-880 | Lådhållare | Bracket | Konsole | Console | |
| 032 | 1 | 334 185-880 | Lådbalk | Box girder beam | Kastenbalken | Poutre en cais- son | M8x12 D16/8,4x1,5 |
| 033 | 2 | 192 238-447 | Skruv | Screw | Schraube | Vis | |
| 034 | 2 | 2151 000-18 | Bricka | Washer | Scheibe | Rondelle | |
| 035 | 1 | 145 145-880 | Pulvertrans- portör, höger- utf. | Flux conveyor, right-hand de- sign | Schweiss- pulver-Trans- porteur, rechtsausführung | Transporteur de flux, con- ception droite | |
| 036 | 1 | 334 726-001 | Sidovägg, vän- ster | Side wall, left | Seitenwand, links | Paroie latérale, gauche | |
| 037 | 1 | 334 726-002 | Sidovägg, höger | Side wall, right | Seitenwand, rechts | Paroie latérale, droite | |
| 038 | 4 | 192 855 001 | Spännrem | Clamping strap | Spannriemen | Courroie de serrage | |
| 039 | 1 | 334 725-001 | Framvägg, höger | Front wall, right | Stirnwand, rechts | Paroie avant, droite | |
| 040 | 1 | 334 725-002 | Framvägg, vänster | Front wall, left | Stirnwand, links | Paroie avant, gauche | |
| 041 | 1 | 334 723-880 | Plattform | Platform | Bühne | Plateform | |
| 042 | 2 | 334 667-880 | Rörgavel | Tube end plate | Rohrendplatte | Plaque termi- nale de tube | |
| 043 | 1 | 334 730-880 | Kapell | Canvas | Zeltplan | Prélart | |
| 044 | 1 | 334 593-000 | Cisternsvet- sautomat | Tank welding automatic | Zisternensch- weissautomat | Machine auto- matique de soudage de récipients | |
| 047 | 1 | 334 727-001 | Platta | Plate | Platte | Plaque | |
| 048 | 2 | 190 437-532 | Skruv | Screw | Schraube | Vis | |
| 049 | 1 | 2183 011-14 | Lyftögla | Lifting eye bolt | Hebeöse | Oeillet de lev- age | |
| 051 | 1 | 192 238-384 | Insexskruv | Allen screw | Innensech- skant- schraube | Vis creuse à six pans | |
| 052 | 1 | 334 055-880 | Nödstopp | Emergency stop | Notaus | Arrêt d'urgence | |





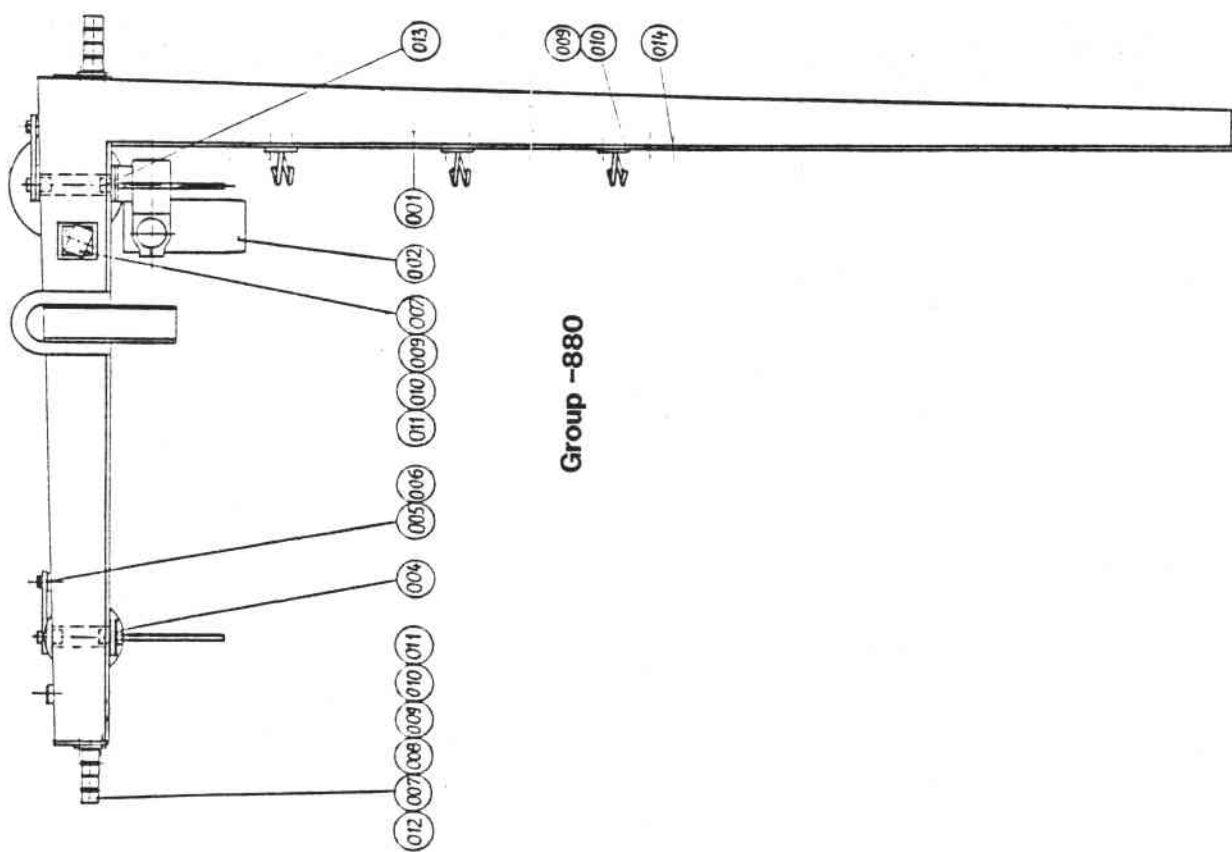
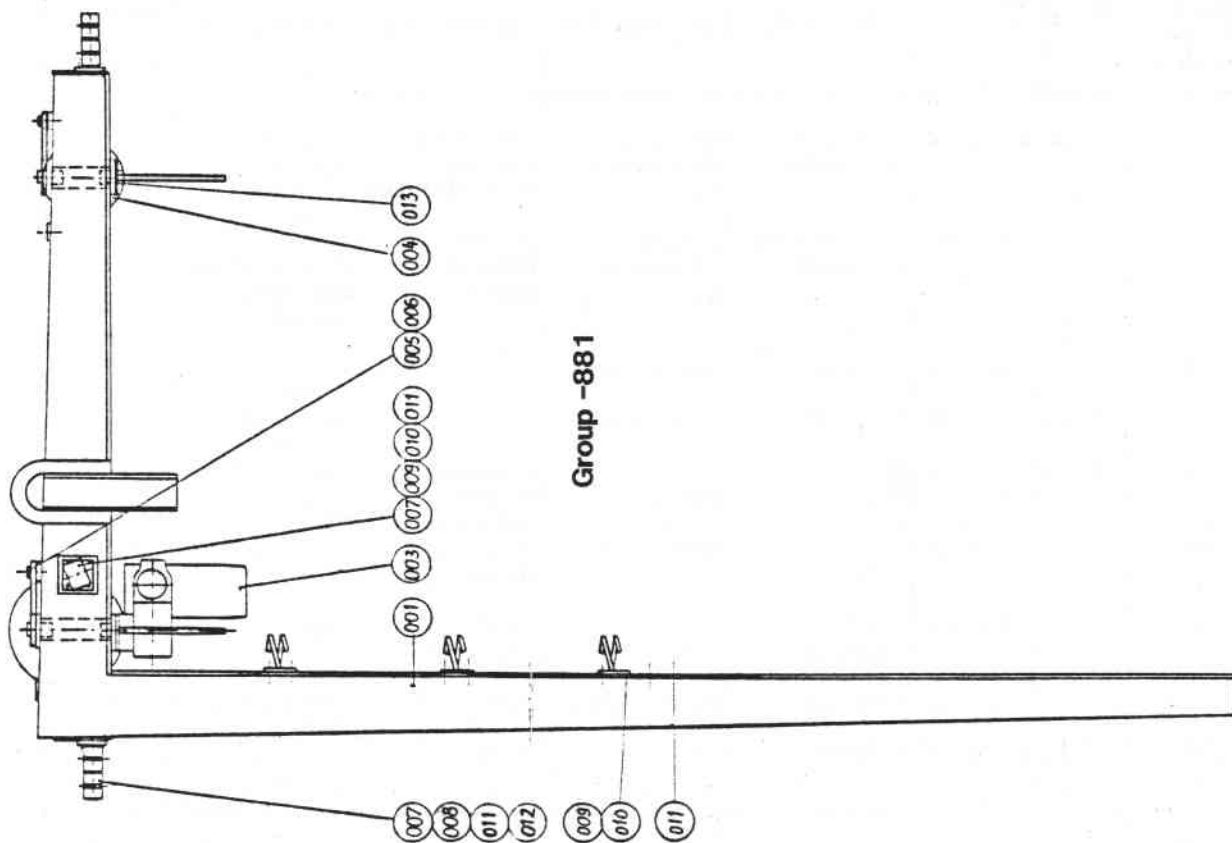
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Group -881

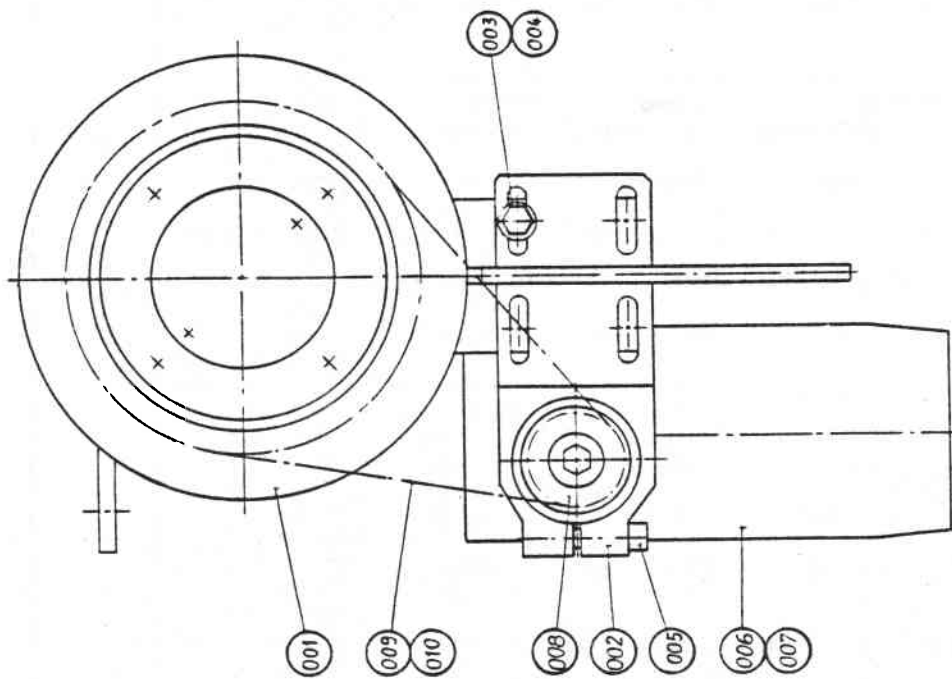
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|---|--------------------------|---|-------------------------------|---|---|---|------------------------------------|
| | | 334 594-880 | Åkvagn, höger- utförande | Carriage, right- hand design | Fahrwerk, rechts-ausführung | Chariot, con- ception droite | |
| | | 334 594-881 | Åkvagn, vän- sterutförande | Carriage, left- hand design | Fahrwerk, linksausführung | Chariot, con- ception gauche | |
| 001 | 1 | 334 664-880 | Vinkelbalk | Angular boom | Winkelbalken | Poutre coudée | |
| 002 | 1 | 334 595-880 | Drivanordning, vänsterutf. | Driving device, left-hand de- sign | Antriebsvor- richtung, links ausführung | Dispositif d'entraînement, conception gauche | |
| 003 | 1 | 334 595-881 | Drivanordning, högerutf. | Driving device, right-hand de- sign | Antriebsvor- richtung, rechtsausführung | Dispositif d'entraînement, conception droite | |
| 004 | 1 | 144 858-880 | Löphjul | Runner | Laufrolle | Galet de roule- ment | |
| 005 | 2 | 2121 017-02 | Skruv | Screw | Schraube | Vis | M20x40 |
| 006 | 2 | 2151 001-11 | Bricka | Washer | Scheibe | Rondelle | D36/21x6 |
| 007 | 3 | 153 756-880 | Klamma | Clamp | Klemme | Bride | |
| 008 | 2 | 153 756-881 | Klamma | Clamp | Klemme | Bride | |
| 009 | 4 | 145 136-880 | Kabelklamma | Cable clamp | Kabelklammer | Crampon de câble | |
| 010 | 8 | 192 238-368 | Skruv | Screw | Schraube | Vis | M6x16 |
| 011 | 12 | 2121 015-59 | Skruv | Screw | Schraube | Vis | M8x25 |
| 012 | 12 | 2151 000-18 | Bricka | Washer | Scheibe | Rondelle | |
| 013 | 4 | 190 240-112 | Lagerbussning | Bearing bus- hing | Lagerbuchse | Coussinet | |
| 014 | 62 | 2155 141-07 | Skyddshylsa | Protecting sle- eve | Schutzhülse | Douille protec- tive | |

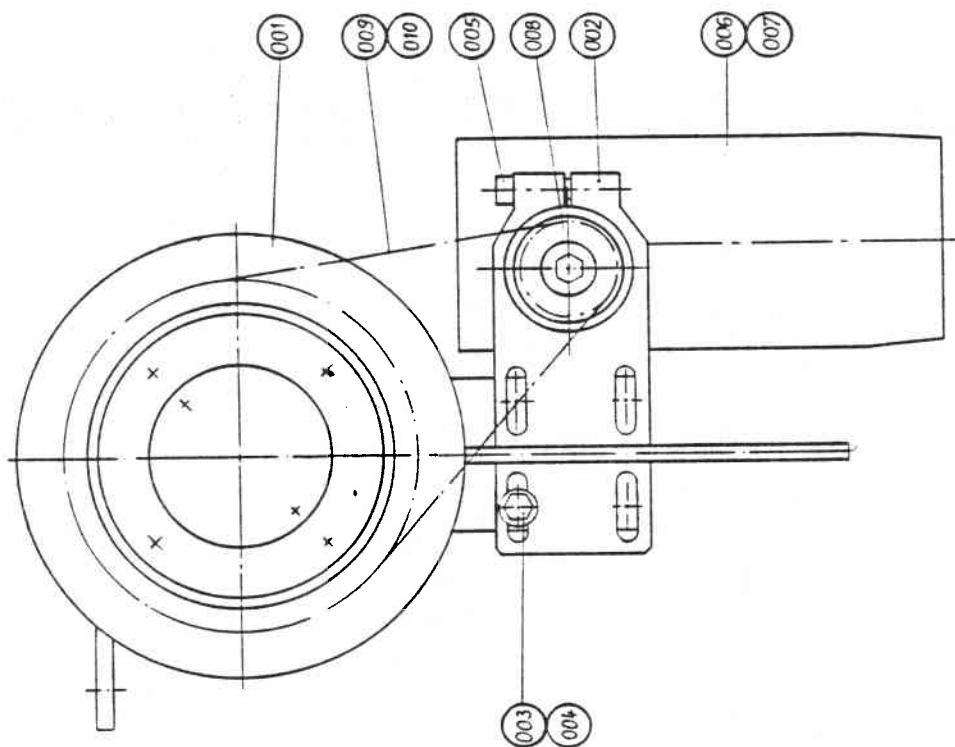


Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|---|---|---|--|------------------------------------|
| | | 334 595-880 | Drivanordning, högerutförande | Driving device, right-hand de- sign | Antriebsvor- richtung, rechtsausführung | Dispositif d'entraînement conception droite | |
| | | 334 595-881 | Drivanordning, vänsterutför- ande | Driving device, left-hand de- sign | Antriebsvor- richtung, links ausführung | Dispositif d'entraînement conception gauche | |
| 001 | 1 | 144 863-880 | Drivhjul | Driving wheel | Antriebsrad | Roue d'entraînement | |
| 002 | 1 | 0304 226-80 | Motorhållare | Motor bracket | Motorkonsole | Support de moteur | |
| 003 | 4 | 190 437-532 | Skruv | Screw | Schraube | Vis | M12x20 |
| 004 | 4 | 190 452-178 | Bricka | Washer | Scheibe | Rondelle | D24/13x2 |
| 005 | 1 | 2121 063-10 | Skruv | Screw | Schraube | Vis | M12x60 |
| 006 | 1 | 147 018-909 | Motor med växel | Motor with gear | Motor mit Get- riebe | Motoréducteur | 42 V 156:1, 2000 rpm |
| 007 | 1 | 147 428-882 | Sladd | Cable | Kabel | Câble | |
| 008 | 1 | 153 754-001 | Kedjehjul | Sprocket | Kettenrad | Pignon à chaîne | |
| 009 | 1 | 2182 015-03 | Rullkedja | Roller chain | Rollenkette | Chaîne à rou- leaux | L=965,2 |
| 010 | 1 | 2182 016-03 | Kedjelås | Chain lock | Kettenschloss | Verrou de chaîne | |



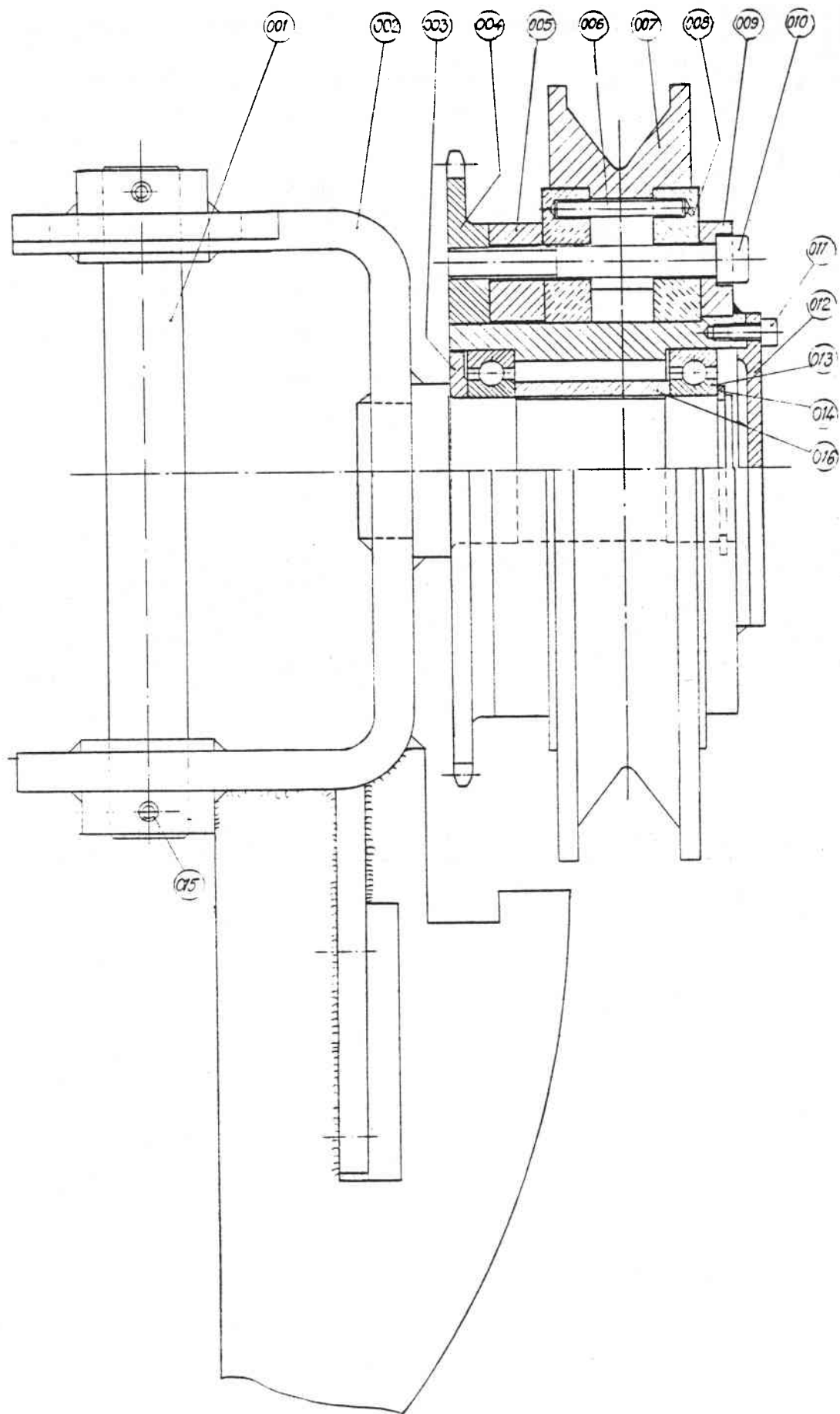
Group -881



Group -880

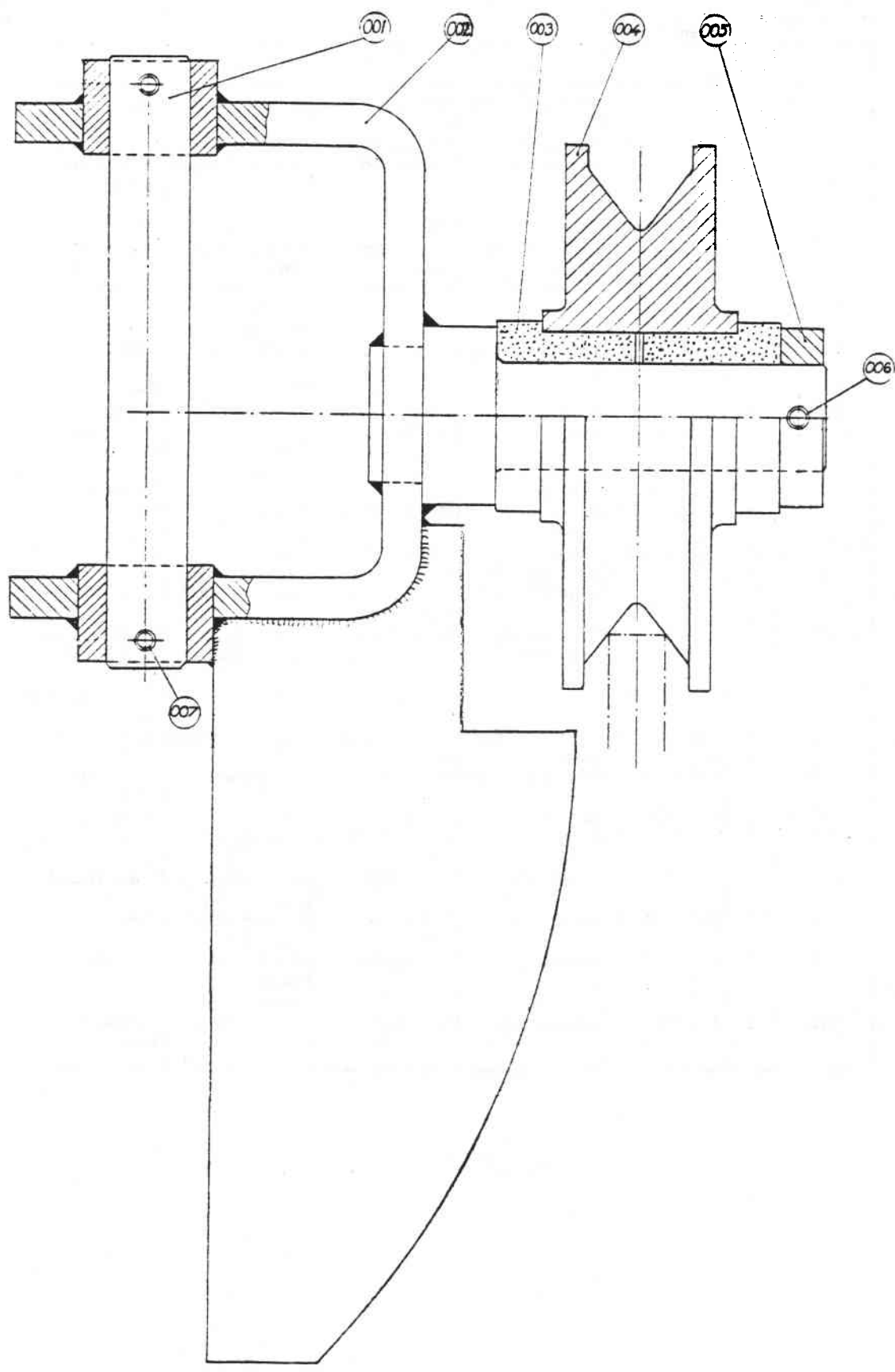
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|---------------|-----------------|-----------------|-------------------------|------------------------------------|
| | | 144 863-880 | Drivhjul | Drive wheel | Antriebsrad | Roue d'entraînement | |
| 001 | 1 | 0408 758-01 | Axelbult | Shaft | Bolzen | Arbre | |
| 002 | 1 | 144 864-880 | Bygel | Clamp | Bügel | Bride | |
| 003 | 1 | 2155 092-01 | Tättningsring | Sealing ring | Radialdichtring | Bague d'étanchéité | |
| 004 | 1 | 2257 012-01 | Kedjehjul | Sprocket | Kettenrad | Pignon à chaîne | |
| 005 | 1 | 2155 089-01 | Distansring | Spacing ring | Zwischenhülse | Bague entreto- ise | |
| 006 | 1 | 2111 029-62 | Rörpinne | Roll pin | Spannstift | Goupille élastique | |
| 007 | 1 | 2292 031-01 | Drivhjul | Drive wheel | Antriebsrad | Roue d'entraînement | |
| 008 | 2 | 2155 090-01 | Isolerring | Insulating ring | Isolierplatte | Bague isolante | |
| 009 | 1 | 2295 008-80 | Nav | Hub | Nabe | Moyeu | |
| 010 | 4 | 2121 063-16 | Skruv | Screw | Schraube | Vis | |
| 011 | 2 | 2121 062-31 | Skruv | Screw | Schraube | Vis | |
| 012 | 1 | 2531 027-01 | Lock | Cover plate | Deckblech | Couvercle | |
| 013 | 2 | 2213 020-12 | Kullager | Ball bearing | Kugellager | Roulement à billes | |
| 014 | 1 | 2157 010-31 | Spårring | Retaining ring | Nutring | Circlips | |
| 015 | 2 | 2111 030-10 | Rörpinne | Roll pin | Spannstift | Goupille élastique | |
| 016 | 1 | 2155 091-01 | Distanshylsa | Spacer sleeve | Zwischenring | Douille entre- toise | |



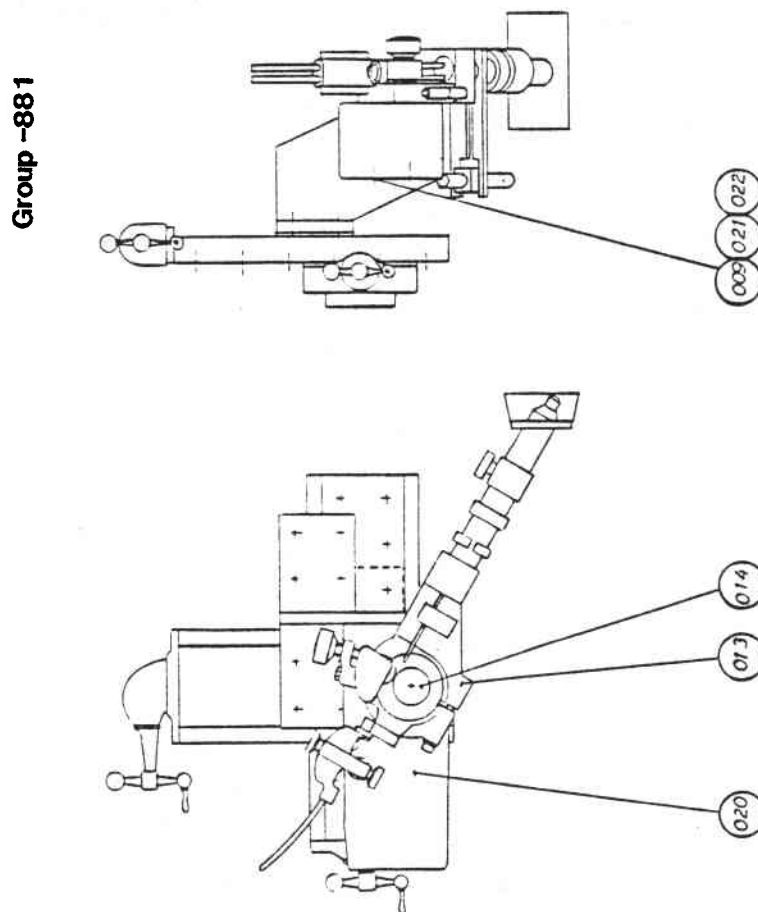
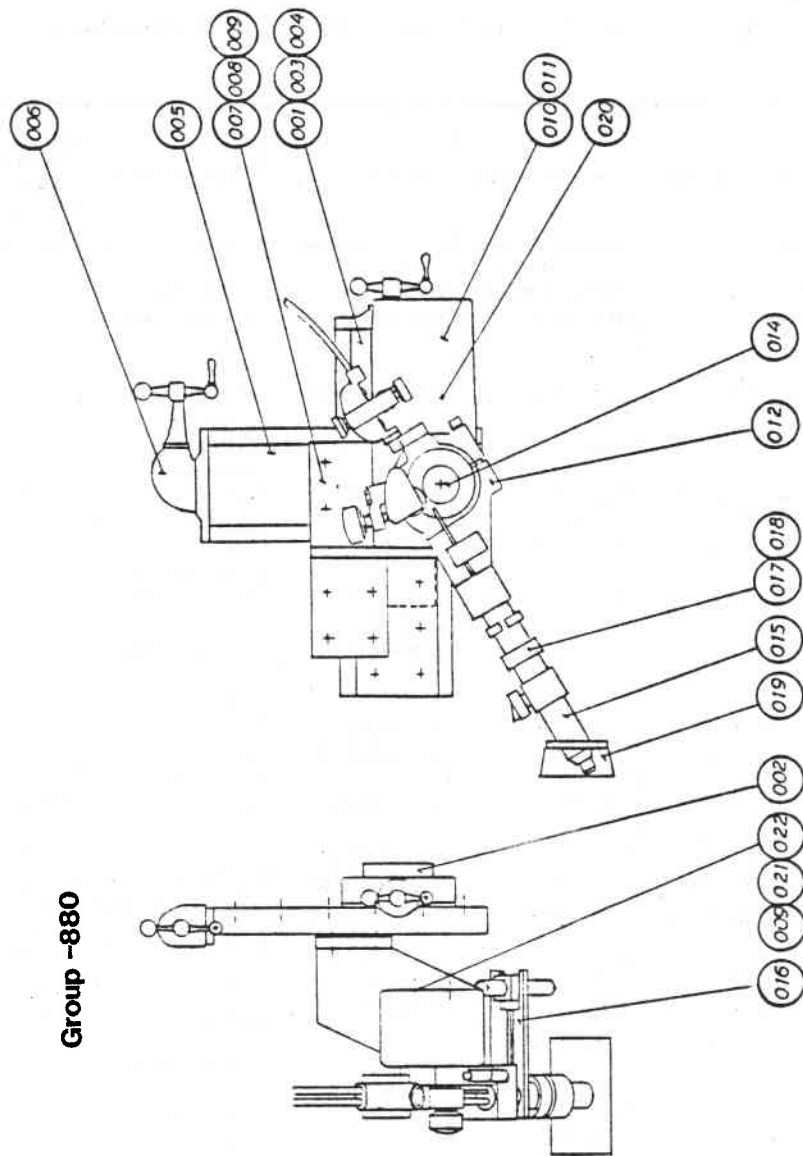
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|---|-------------------------|------------------------|--------------|------------------------|------------------------------------|
| | | 144 858-880 | Löphjul | Bogie wheel | Laufrad | Roue d'atterrissage | |
| 001 | 1 | 0408 755-01 | Axelbult | Shaft | Achse | Arbre | |
| 002 | 1 | 144 861-880 | Bygel | Clamp | Bügel | Bride | |
| 003 | 2 | 0408 756-01 | Isoleringsbuss- ning | Insulating sle- eve | Isolierhülse | Douille d'isolation | |
| 004 | 1 | 2292 030-01 | Hjul | Wheel | Rad | Roue | |
| 005 | 1 | 0408 757-01 | Stoppring | Lock ring | Haltering | Bague d'arrêt | |
| 006 | 1 | 2111 030-26 | Rörpinne | Roll pin | Spannstift | Goupille élastique | |
| 007 | 2 | 2111 030-10 | Rörpinne | Roll pin | Spannstift | Goupille élastique | |



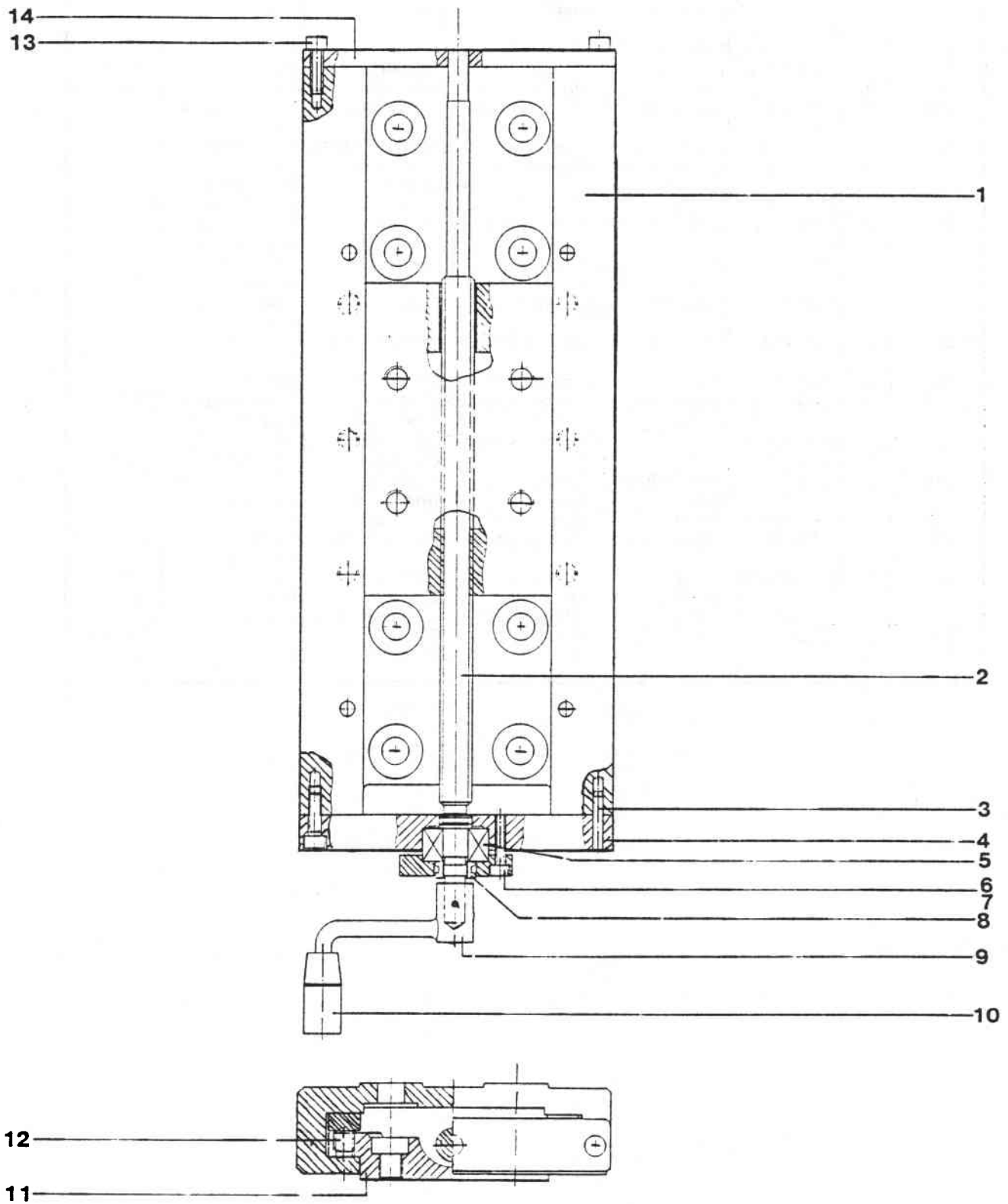
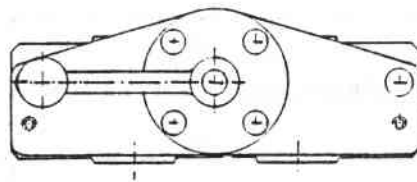
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|---------------------------------------|---|-------------------------------------|--|------------------------------------|
| | | 334 660-880 | Svets huvud, högerutförande | Welding head, right-hand de- sign | Schweissskopf, rechtsausführung | Tête de sou- dage, concep- tion droite | |
| | | 334 660-881 | Svets huvud, vänsterutför- ande | Welding head, left-hand de- sign | Schweissskopf, linksausführung | Tête de sou- dage, concep- tion gauche | |
| 001 | 1 | 154 465-882 | Slid | Slide | Schlitten | Glissière | |
| 002 | 1 | 145 399-001 | Förstärknings- platta | Reinforcement plate | Verstärkungs- platte | Plaque de ren- forcement | |
| 003 | 12 | 190 437-532 | Insexskruv | Allen screw | Innensech- skant- schraube | Vis creuse à six pans | M12x20 |
| 004 | 12 | 190 452-178 | Bricka | Washer | Scheibe | Rondelle | D24/13x2 |
| 005 | 1 | 154 465-881 | Slid | Slide | Schlitten | Glissière | |
| 006 | 1 | 2377 002-80 | Vinkelväxel | Angular gear | Winkelgetriebe | Renvoi d'angle | |
| 007 | 1 | 153 745-880 | Konsol | Bracket | Konsole | Console | |
| 008 | 8 | 2121 016-05 | Insexskruv | Allen screw | Innensech- skant- schraube | Vis creuse à six pans | M10x25 |
| 009 | 10 | 2151 000-23 | Bricka | Washer | Scheibe | Rondelle | D22/10,5x2 |
| 010 | 1 | 145 063-887 | Motor med växel | Motor with gear | Motor mit Get- riebe | Moteur avec réducteur | |
| 011 | 1 | 147 428-880 | Sladd | Cable | Kabel | Câble | |
| 012 | 1 | 147 639-880 | Riktrulleverk högerutf. | Straightener, right-hand de- sign | Drahtrichtwerk, rechtsausführung | Dresse-fil, con- ception droite | |
| 013 | 1 | 147 639-881 | Riktrulleverk, vänsterutf. | Straightener, left-hand de- sign | Drahtrichtwerk, linksausführung | Dresse-fil, con- ception gauche | |
| 014 | 1 | 2188 101-83 | Handratt | Handwheel | Handrad | Volant de com- mande | |
| 015 | 1 | 334 291-887 | Kontaktutrust- ning | Contact equip- ment | Kontaktausrüstung | Équipement de contact | |
| 016 | 1 | 153 143-880 | Projektorlampa | Guide lamp | Lichtpunkt lampe | Lampe de gui- dage | |
| 017 | 1 | 145 132-880 | Klamma | Clamp | Klemme | Bride | |
| 018 | 1 | 145 131-001 | Isolerhylsa | Insulating sle- eve | Isolierhülse | Douille isolante | |
| 019 | 1 | 145 380-880 | Pulverstöd | Flux support | Schweiss- pulver stütz | Support de flux | |
| 020 | 2 | 2155 141-05 | Skyddshylsa | Protective sle- eve | Schutzhülse | Douille protec- tive | |
| 021 | 2 | 2121 016-12 | Insexskruv | Allen screw | Innensech- skant- schraube | Vis creuse à six pans | M10x60 |
| 022 | 2 | 191 418-024 | Distanshylsa | Spacer sleeve | Zwischenring | Douille entre- toise | |



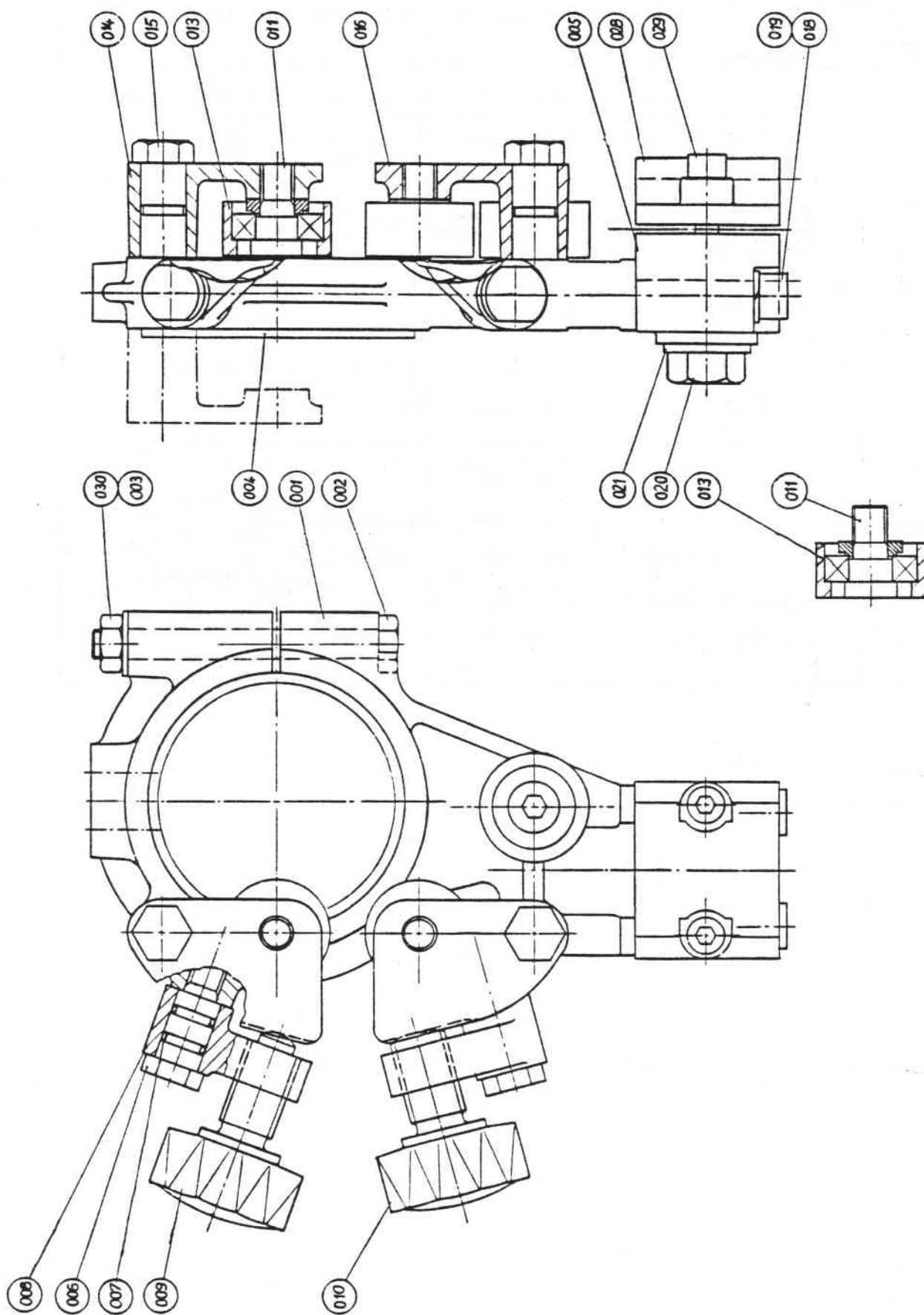
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|-----------------------|---------------------------|-----------------------------|--|------------------------------------|
| | | 154 465-881 | Slid, hand-driven | Slide, manually operated | Schlitten, handbetrieben | Glissière, commande manuelle | |
| 1 | 1 | 154 464-002 | Slidprofil | Slide frame | Schlittenprofil | Profilé de glissière | |
| 2 | 1 | 154 461-002 | Ledarskruv | Lead screw | Führungsschraube | Vis de commande | |
| 3 | 2 | 2111 029-57 | Fjädrande rörpinne | Roll pin | Spannstift | Goupille élastique | D5x20 |
| 4 | 1 | 154 458-001 | Ändstycke | End piece | Endstück | Pièce d'extrémité | |
| 5 | 1 | 190 531-201 | Kullager | Ball bearing | Kugellager | Roulement à billes | SKF3201 |
| 6 | 1 | 154 457-001 | Kullageröverfall | Ball bearing cap | Kugellagerdeckel | Chapeau de palier à roulement à billes | |
| 7 | 4 | 192 238-329 | Skruv | Screw | Schraube | Vis | M5x16 |
| 8 | 1 | 154 456-001 | Låsmutter | Locknut | Sicherungsmutter | Ecrou de blocage | |
| 9 | 1 | 2111 029-38 | Fjädrande rörpinne | Roll pin | Spannstift | Goupille élastique | D3x20 |
| 10 | 1 | 334 537-001 | Handvev | Crank | Handkurbel | Manivelle | |
| 11 | 1 | 154 463-880 | Löpare med glidskenor | Carriage with slide rails | Schlitten mit Gleitschienen | Curseur avec rails de glissement | |
| 12 | 6 | 190 509-485 | Stoppskruv | Stop screw | Anschlagsschraube | Vis d'arrêt | M10x10 |
| 13 | 4 | 192 238-370 | Skruv | Screw | Schraube | Vis | M6x20 |
| 14 | 1 | 154 459-001 | Ändbricka | End washer | Endscheibe | Plaque d'extrémité | |
| 15 | 8 | 190 437-532 | Skruv | Screw | Schraube | Vis | M12x20 |
| 16 | 8 | 190 452-178 | Bricka | Washer | Scheibe | Rondelle | D24/13x2 |
| 17 | 4 | 192 238-493 | Skruv | Screw | Schraube | Vis | M10x25 |



Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|----------------------------|--------------------------|---------------------------|--------------------------------|------------------------------------|
| | | 147 639-880 | Riktrulleverk (höger) | Straightener (right) | Drahtrichtwerk (recht) | Dresse-fil (dro- ite) | |
| | | 147 639-881 | Riktrulleverk (vänster) | Straightener (left) | Drahtrichtwerk (links) | Dresse-fil (gau- che) | |
| 001 | 1 | 156 449-001 | Klämma | Clamp | Klemme | Bride | M10x100 D22/10,5x2 |
| 002 | 1 | 2121 016-18 | Skruv | Screw | Schraube | Vis | |
| 003 | 1 | 2151 000-23 | Bricka | Washer | Scheibe | Rondelle | |
| 004 | 1 | 2155 036-01 | Isolerhylsa | Insulating sle- eve | Isolierhülse | Douille isolante | |
| 005 | 1 | 156 530-001 | Klamhalva | Clamp half | Klemmenhälfte | Demi-bride | D11,3x2,4 |
| 006 | 2 | 2129 000-01 | Distansskruv | Spacer screw | Abstandss- chraube | Vis d'écartement | |
| 007 | 4 | 2152 012-09 | O-ring | O-ring | O-ring | Joint torique | |
| 008 | 2 | 2184 008-01 | Arm till tryck- rulle | Pressure roller arm | Arm für Drückrolle | Bras pour galet de pression | |
| 009 | 1 | 2188 101-81 | Handratt | Handwheel | Handrad | Volant de com- mande | |
| 010 | 1 | 2188 101-82 | Handratt | Handwheel | Handrad | Volant de com- mande | |
| 011 | 3 | 332 411-880 | Axeltapp | Stub shaft | Wellenstumpf | Tourillon d'arbre | |
| 013 | 3 | 153 148-880 | Rulle | Roller | Rolle | Galet | |
| 014 | 1 | 156 528-001 | Huv till tryck- rulle | Thrust roller carrier | Haube für Druckrolle | Capot de galet pression | M10x60 D18,1/10,2 |
| 015 | 2 | 2129 026-01 | Distansskruv | Spacer screw | Abstandss- chraube | Vis d'écartement | |
| 016 | 1 | 156 529-001 | Huv till tryck- rulle | Thrust roller carrier | Haube für Druckrolle | Capot de galet pression | |
| 018 | 2 | 192 238-503 | Skruv | Screw | Schraube | Vis | |
| 019 | 2 | 2195 010-13 | Fjäderbricka | Spring washer | Federscheibe | Rondelle élastique | M16x50 D30/17x3 |
| 020 | 1 | 2121 016-54 | Skruv | Screw | Schraube | Vis | |
| 021 | 1 | 2151 000-31 | Bricka | Washer | Scheibe | Rondelle | |
| 028 | 1 | 156 531-001 | Klamhalva | Clamp half | Klemmenhälfte | Demi-bride | |
| 029 | 2 | 192 238-455 | Skruv | Screw | Schraube | Vis | M8x30 M10 |
| 030 | 1 | 2126 011-10 | Mutter | Nut | Mutter | Ecrou | |

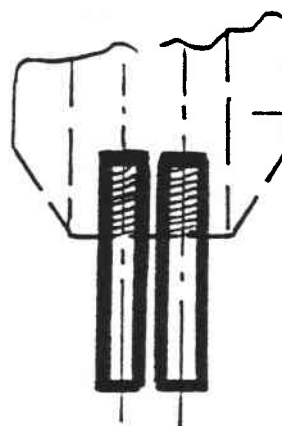
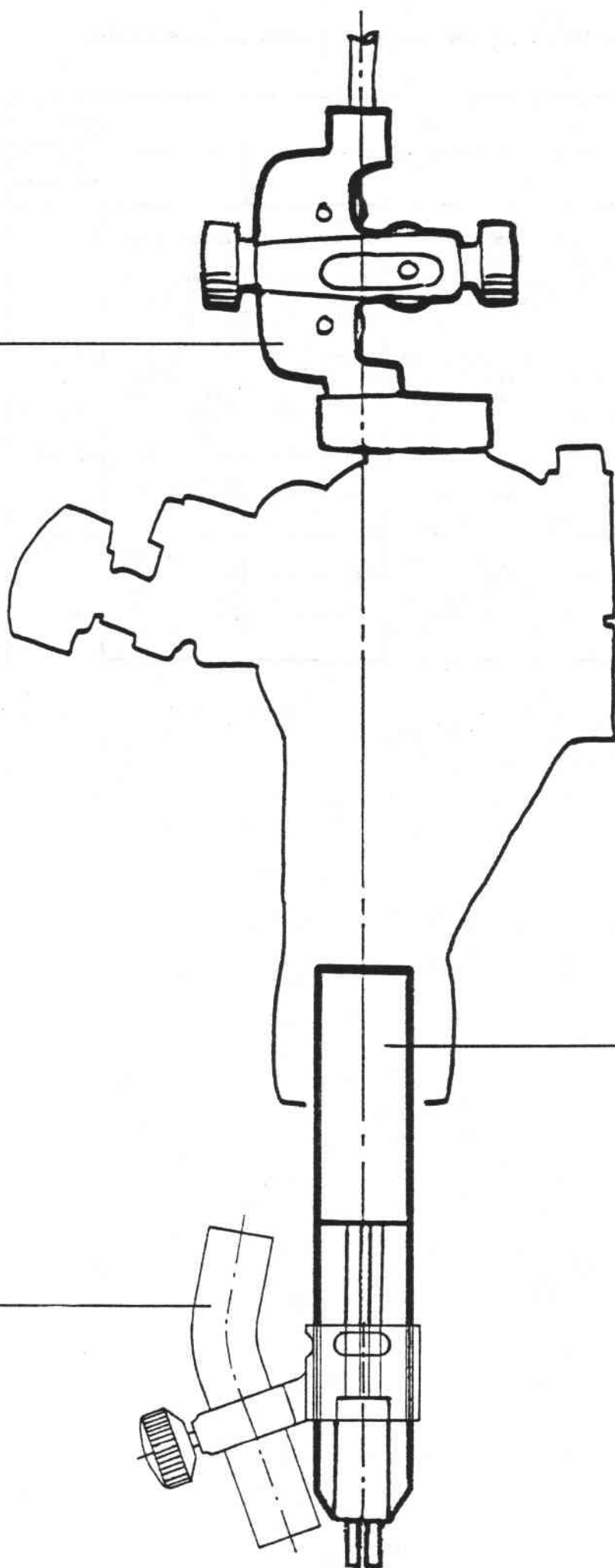


Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|--|---|---|---|------------------------------------|
| | | 334 291-880 334 291-881 334 291-884 334 291-885 | Kontaktutrust- ning Twinarc, med mun- stycksfäste | Contact equip- ment Twin-arc, with nozzle holder | Kontaktaus- rüstung Twin-arc, mit Düsenhalterung | Equipement de contact Twinarc, avec Support de buse | D35 |
| 1 | 1 | 333 852-880 | Kontaktton | Contact device | Stromrohr | Tube-contact | L = 220 |
| 2 | 1 | 333 852-881 | Kontaktton | Contact device | Stromrohr | Tube-contact | L = 275 |
| 3 | 2 | 153 501-005 | Kontaktmun- stycke | Contact tip | Kontaktdüse | Buse de con- tact | &dia1,2 |
| 4 | 2 | 153 501-007 | Kontaktmun- stycke | Contact tip | Kontaktdüse | Buse de con- tact | &dia1,6 |
| 5 | 2 | 153 501-009 | Kontaktmun- stycke | Contact tip | Kontaktdüse | Buse de con- tact | &dia2,0 |
| 6 | 2 | 153 501-010 | Kontaktmun- stycke | Contact tip | Kontaktdüse | Buse de con- tact | &dia2,5 |
| 7 | 1 | 153 299-880 | Pulvermun- stycke | Flux nozzle | Pulverdüse | Buse à flux | |
| 8 | 1 | 145 787-880 | Klentrådsrikt- verk | Fine wire straightener | Kleindrahtrech- werk | Dresse-fil pour fils fins | |
| 9 | 1 | 2185 224-86 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia1,2 |
| 10 | 1 | 2185 224-88 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia1,6 |
| 11 | 1 | 2185 224-84 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia2,0 |
| 12 | 1 | 2185 224-80 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia2,5 |
| 13 | 1 | 2185 224-81 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia3,0 |

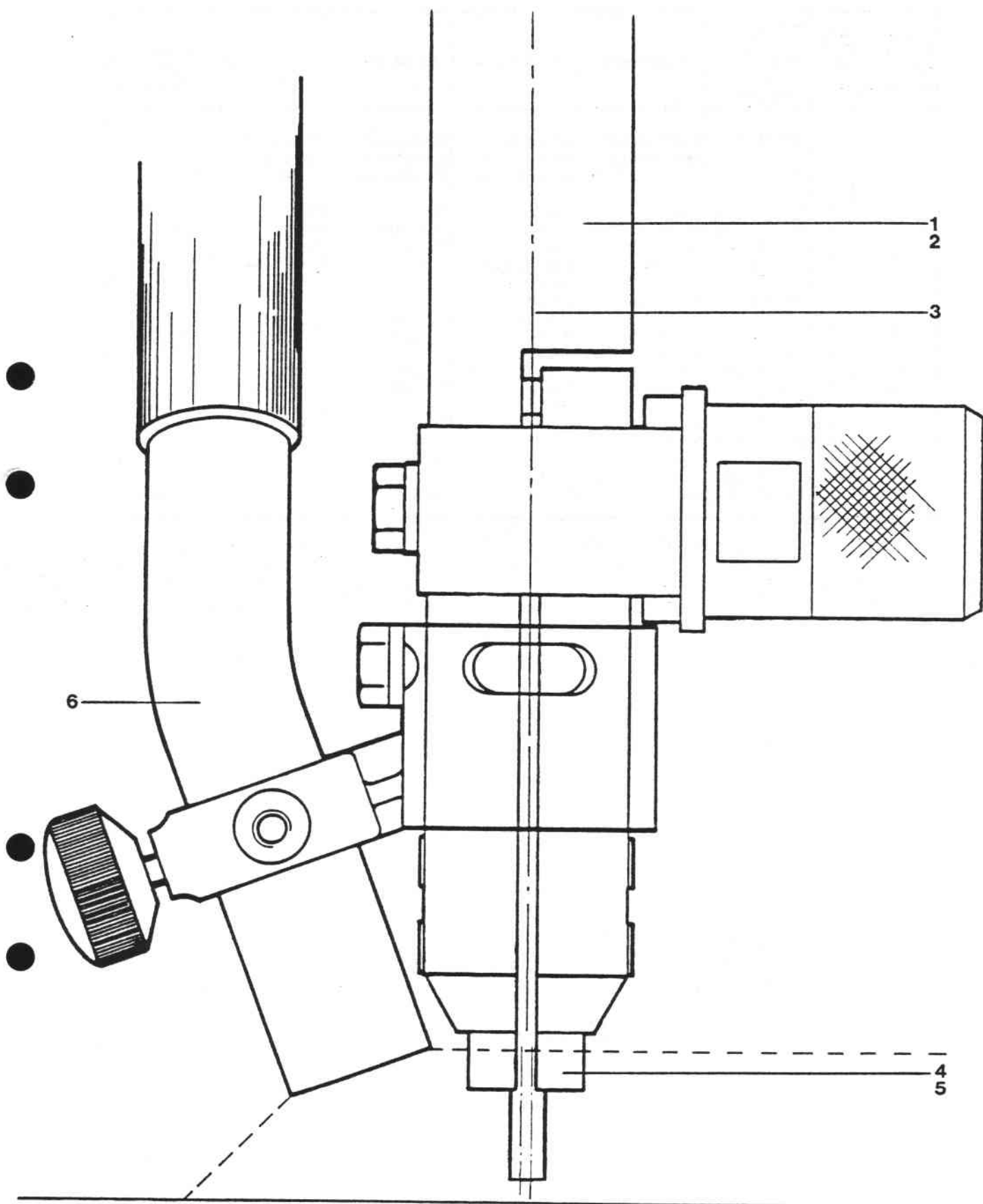
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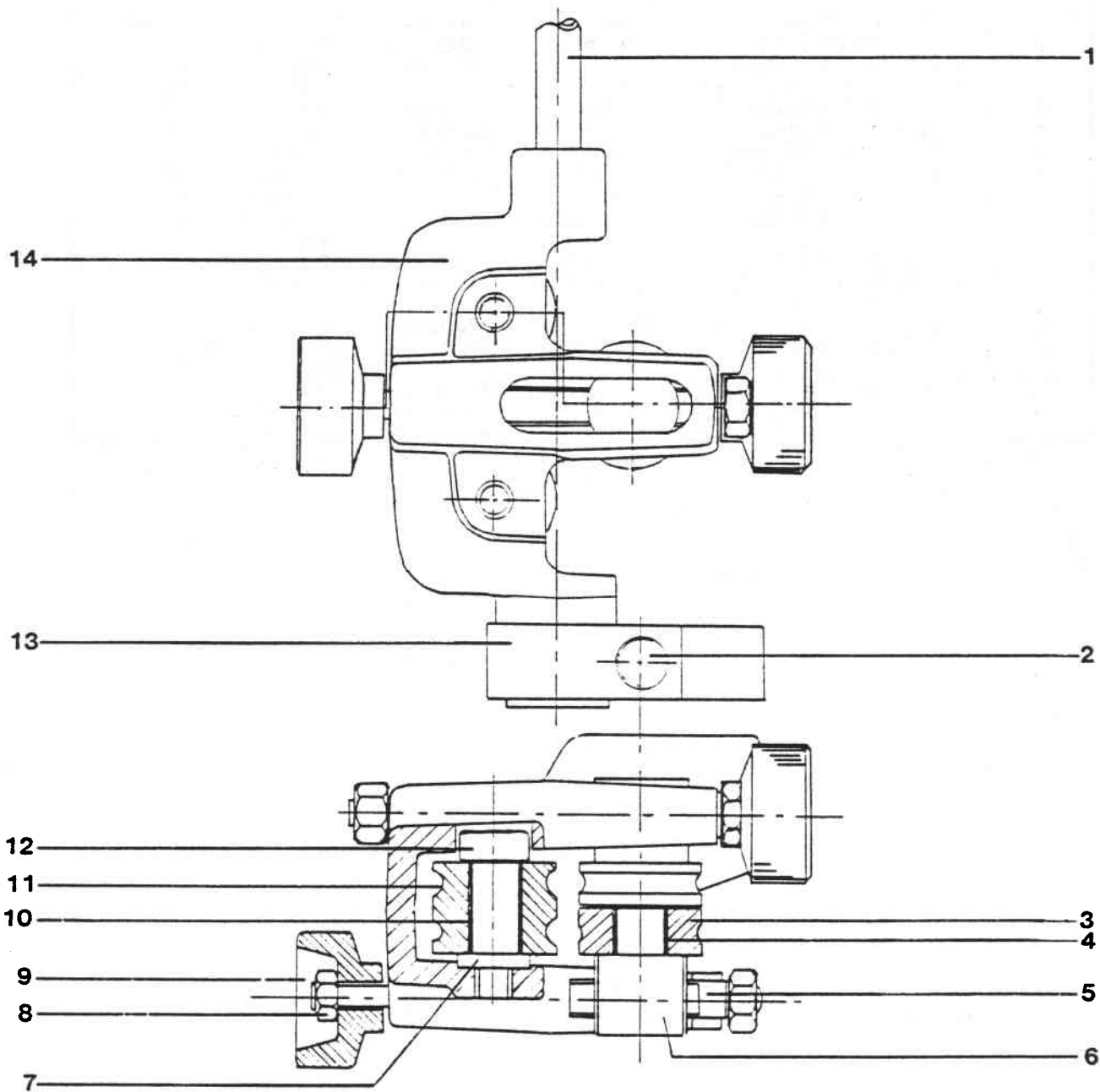
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|---|--|---|--|------------------------------------|
| | | 334 291-882 334 291-883 334 291-886 334 291-887 | Kontaktutrust- ning Twinarc, med kontakt- back | Contact equip- ment Twinarc, with contact jaw | Kontaktaus- rüstung Doppeldraht, mit Kontakt- backe | Equipment de contact Twinarc, avec mâchoire de contact | D35 |
| 1 | 1 | 2166 027-82 | Kontaktodon | Contact device | Stromrohr | Tube-contact | L = 220 |
| 2 | 1 | 2166 027-81 | Kontaktodon | Contact device | Stromrohr | Tube-contact | L = 275 |
| 3 | 1 | 334 278-881 | Rörinsats | Insert tube | Rohreinsatz | Insert tubulaire | |
| 4 | 1 | 2659 028-80 | Kontaktback | Contact jaw | Kontaktbacke | Mâchoire de contact | &dia2,5-3,0 |
| 5 | 1 | 2659 028-81 | Kontaktback | Contact jaw | Kontaktbacke | Mâchoire de contact | &dia2,0 |
| 6 | 1 | 153 299-880 | Pulvermun- stycke | Flux nozzle | Pulverdüse | Buse à flux | |
| 7 | 1 | 2185 224-84 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia2,0 |
| 8 | 1 | 2185 224-80 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia2,5 |
| 9 | 1 | 2185 224-81 | Matarrulle | Feed roller | Vorschubrolle | Galet d'alimentation | &dia3,0 |



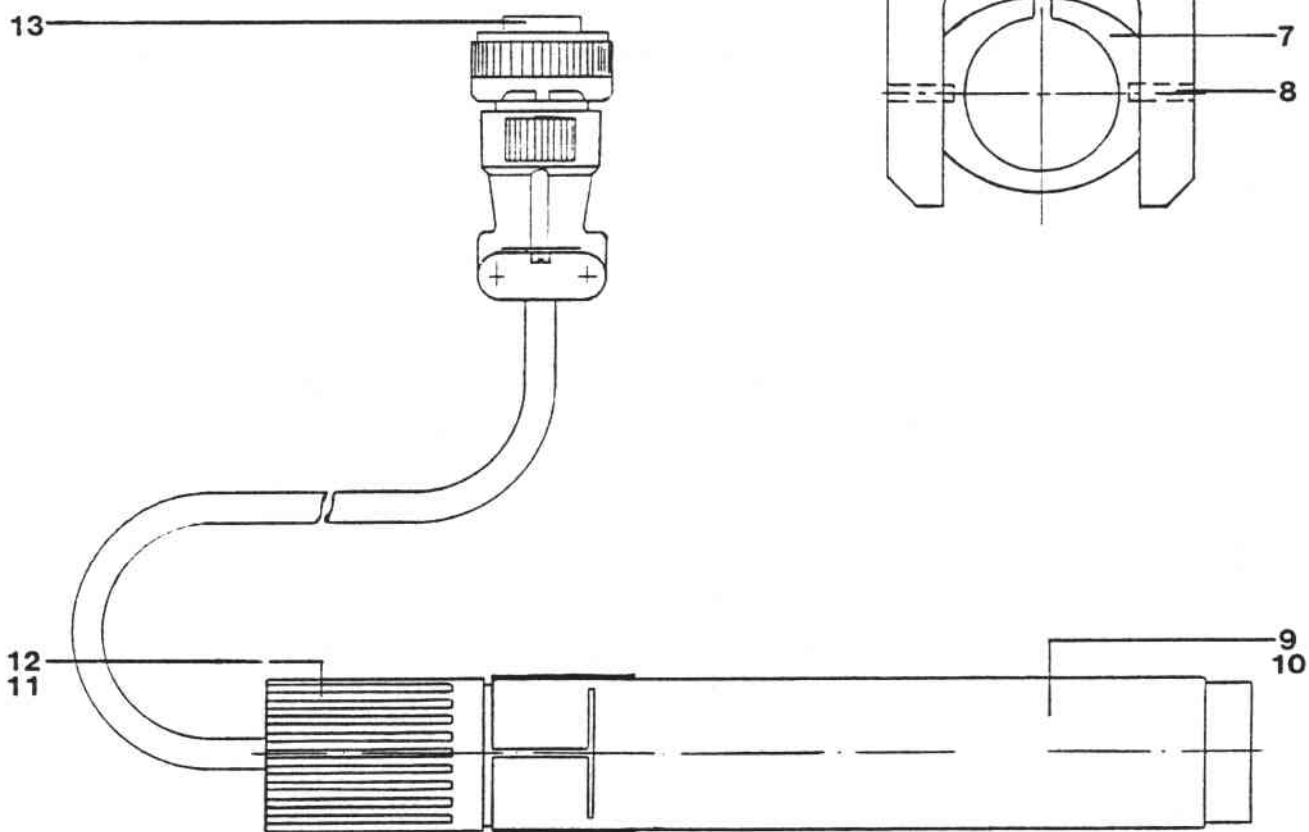
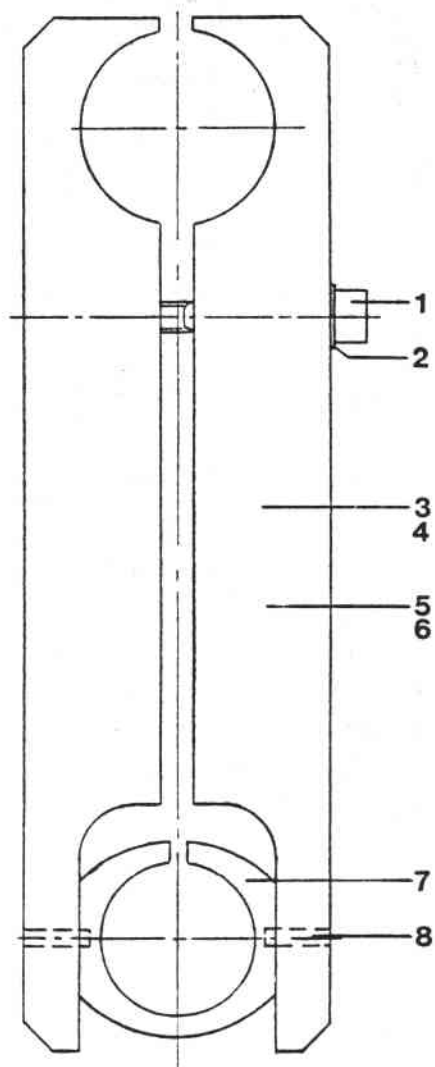
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|---|---|---|---|---|------------------------------------|
| | | 145 787-880 | Klentrådsrikt- verk, för dub- belektrod | Fine wire straightener, for twin wire | Kleindraht richtverk, für Doppeldraht | Dresse-fil pour fils fins, pour fil jumelés | |
| 1 | 1 | 151 287-001 | Slang | Hose | Schlauch | Tuyau | L = 300 |
| 2 | 1 | 2121 062-50 | Skruv | Screw | Schraube | Vis | M8x25 |
| 3 | 1 | 145 790-001 | Rulle | Roller | Rolle | Galet | |
| 4 | 1 | 190 240-103 | Lagerbussning | Bearing bus- hing | Lagerbuchse | Coussinet | D12/10 |
| 5 | 2 | 145 796-001 | Skruv | Screw | Schraube | Vis | |
| 6 | 1 | 145 793-001 | Löpare | Runner | Schlitten | Curseur | |
| 7 | 2 | 2151 001-03 | Bricka | Washer | Scheibe | Rondelle | D16/8,4x3 |
| 8 | 2 | 190 735-318 | Mutter | Nut | Mutter | Ecrou | M8 |
| 9 | 1 | 145 794-001 | Rat | Knob | Knebel | Bouton | |
| 10 | 2 | 145 791-001 | Lagerbussning | Bearing bus- hing | Lagerbuchse | Coussinet | |
| 11 | 2 | 145 789-001 | Rulle | Roller | Rolle | Galet | |
| 12 | 2 | 145 792-001 | Skruv | Screw | Schraube | Vis | |
| 13 | 1 | 145 795-001 | Länk | Link | Gelenk | Maillon | |
| 14 | 1 | 145 788-001 | Hus | Case | Gehäuse | Carter | |
| 15 | 2 | 190 455-451 | Skruv | Screw | Schraube | Vis | M8x20 |



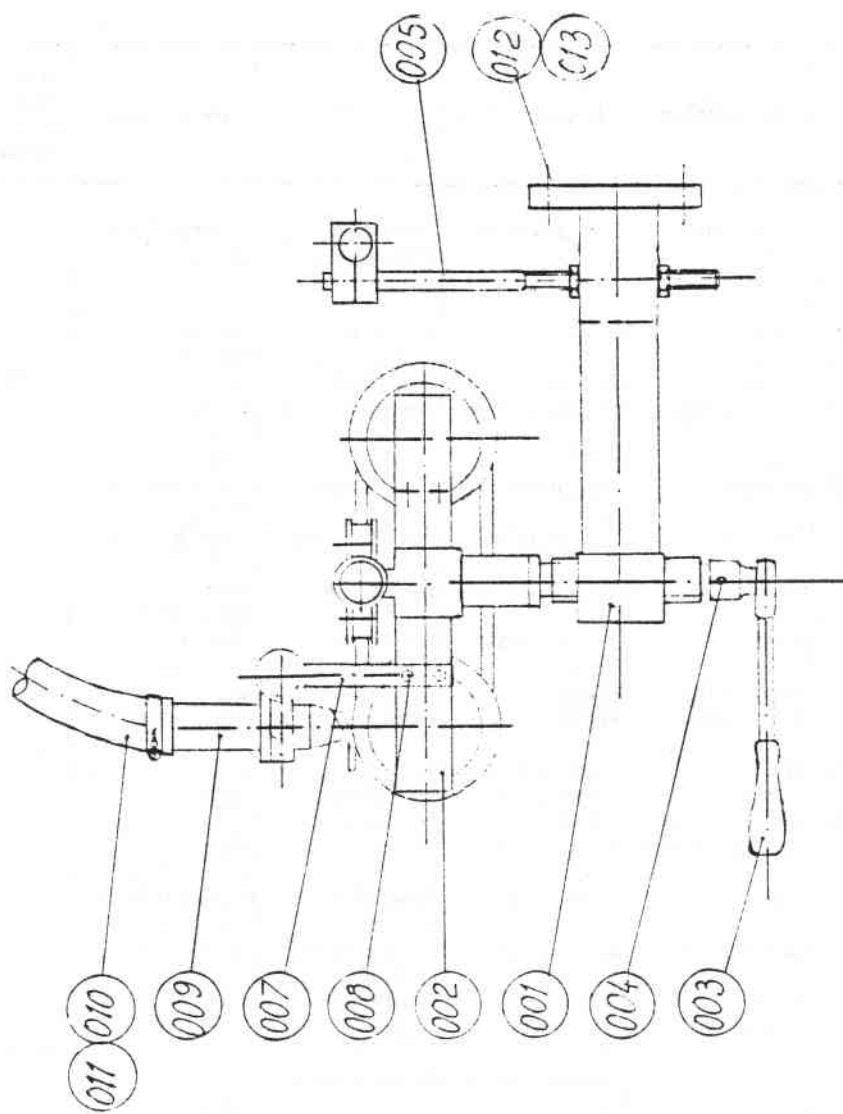
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|---|-------------------------|---------------------|--------------------------|--------------------------------|------------------------------------|
| | | 153 143-880 | Projektorlampa kompl | Guide lamp compl | Lichtpunkt lampe kpl | Lampe de gui- dage complete | D 35 |
| | | 153 143-882 | Projektorlampa kompl | Guide lamp compl | Lichtpunkt- lampe kpl | Lampe de gui- dage complete | D 20 |
| 1 | 1 | 2121 062-39 | Skruv | Screw | Schraube | Vis | M6x50 |
| 2 | 1 | 2151 000-13 | Bricka | Washer | Scheibe | Rondelle | D12/6,4x1,5 |
| 3 | 1 | 153 141-002 | Hållare, halv | Holder | Halterung | Support | D35 |
| 4 | 1 | 153 141-004 | Hållare, halv | Holder | Halterung | Support | D20 |
| 5 | 1 | 153 141-001 | Hållare, halv | Holder | Halterung | Support | D35 |
| 6 | 1 | 153 141-003 | Hållare | Holder | Halterung | Support | D20 |
| 7 | 1 | 153 401-001 | Bussning | Bushing | Buchse | Douille | |
| 8 | 2 | 2111 029-34 | Fjädrande rör- pinne | Roll pin | Spannstift | Goupille élastique | D3x12 |
| 9 | 1 | 153 142-880 | Projektorlampa | Guide lamp | Lichtpunkt- lampe | Lampe de gui- dage | |
| 10 | 1 | 153 142-002 | Linsrör | Lens tube | Linsenrohr | Tube lentille | |
| 11 | 1 | 153 142-001 | Lamphållare | Lamp socket | Lampenhalter | Support de lampe | |
| 12 | 1 | 157 172-001 | Glödlampa | Bulb | Glühlampe | Ampoule | |
| 13 | 1 | 5385 011-04 | Stiftpropp | Pin plug | Stiftstecker | Fiche mâle fu- sible | |
| 14 | 1 | 153 143-881 | Hållare | Holder | Halterung | Support | |
| 15 | 1 | 153 143-883 | Hållare, halv | Holder | Halterung | Support | |

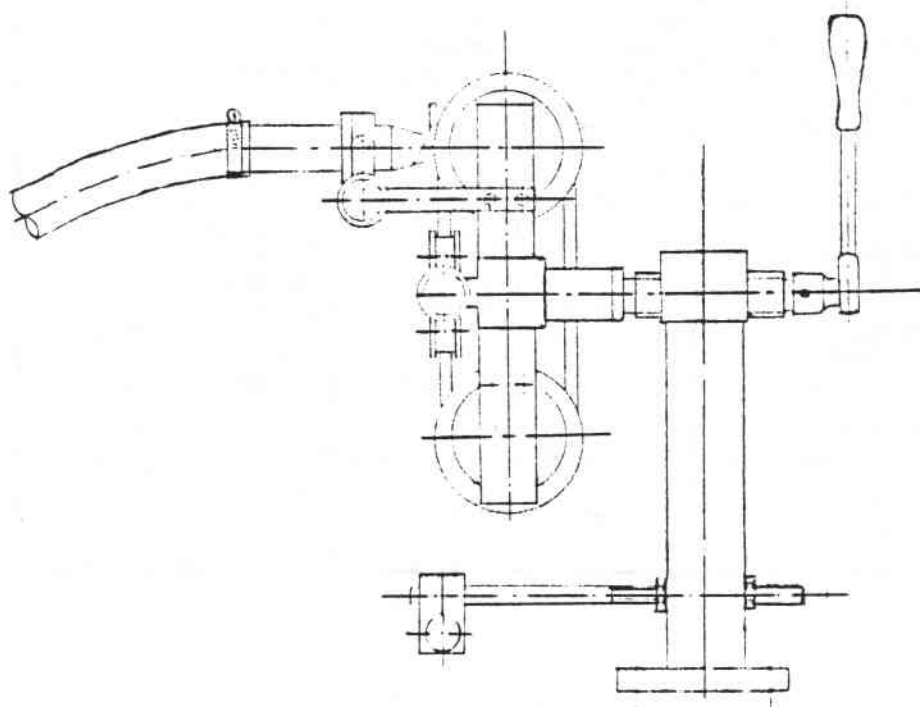


Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|---|--------------------------------|--|---|------------------------------------|
| | | 145 145-880 | Pulvertrans- portör, höger kompl. | Flux support, right compl. | Schweiss- pulver- stütze, rechts kpl. | Transporteur de flux, droit compl. | |
| | | 145 145-881 | Pulvertrans- portör, vänster kompl. | Flux support, left compl. | Schweiss- pulver- stütze, links kpl. | Transporteur de flux, gauche compl. | |
| 001 | 1 | 144 853-880 | Fästarm | Holder | Halter | Bras de fixation | |
| 002 | 1 | 144 850-880 | Pulvertrans- portör | Flux support | Schweiss- pulver- stütze | Transporteur de flux | |
| 003 | 1 | 145 137-880 | Spärrnyckel med hylsa | Blocking key with collar | Ratschen- schlüssel | Clef à rochet avec douille | |
| 004 | 1 | 2111 029-72 | Fjädrande rör- pinne | Springing roll pin | Federspann- stift | Goupille élastique | |
| 005 | 1 | 153 748-880 | Klamma med fäste | Clamp with holder | Klammer mit Befestigung | Bride avec support | |
| 007 | 1 | 145 144-880 | Hållare för sugmunstycke | Holder for suc- tion nozzle | Halter für Saugdüse | Support pour buse d'aspiration | |
| 008 | 2 | 2121 062-50 | Skruv | Screw | Schraube | Vis | |
| 009 | 1 | 145 394-001 | Sugmunstycke | Suction nozzle | Saugdüse | Buse d'aspiration | |
| 010 | 1 | 190 789-801 | Sugslang | Suction hose | Saugschlauch | Tuyau d'aspiration | L = 800 |
| 011 | 2 | 2529 004-09 | Klamma | Hose clip | Schlauch- klemme | Collier de ser- rage | |



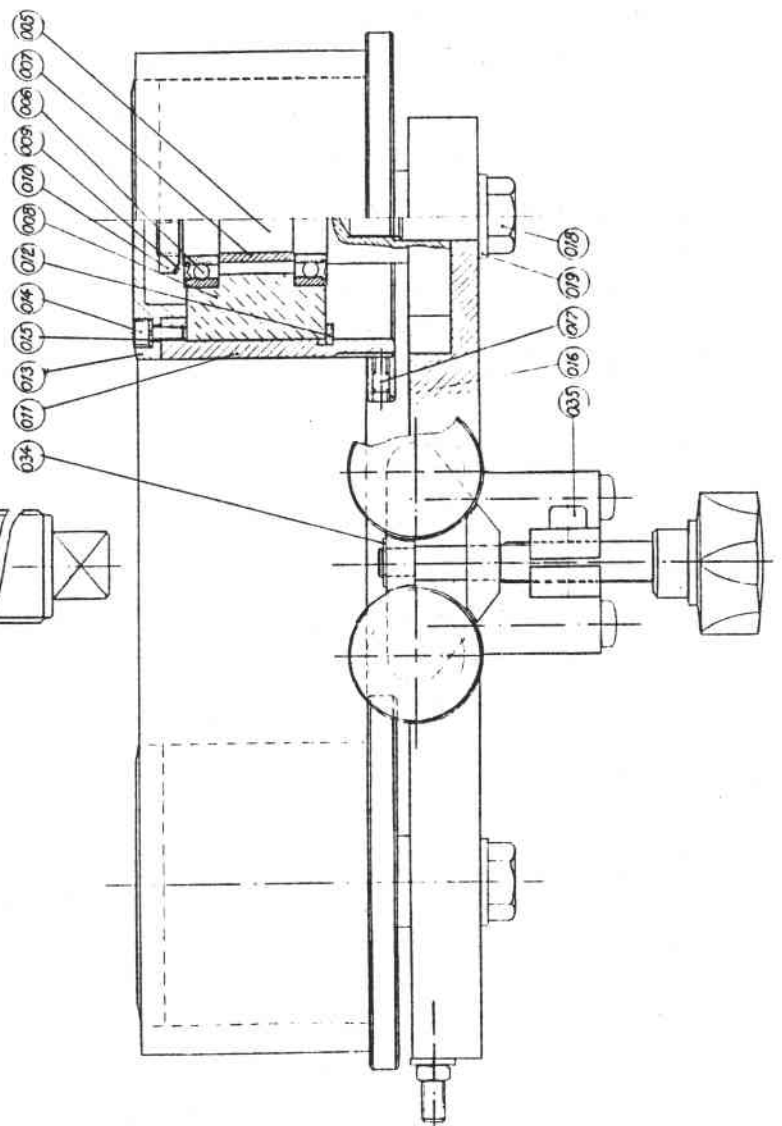
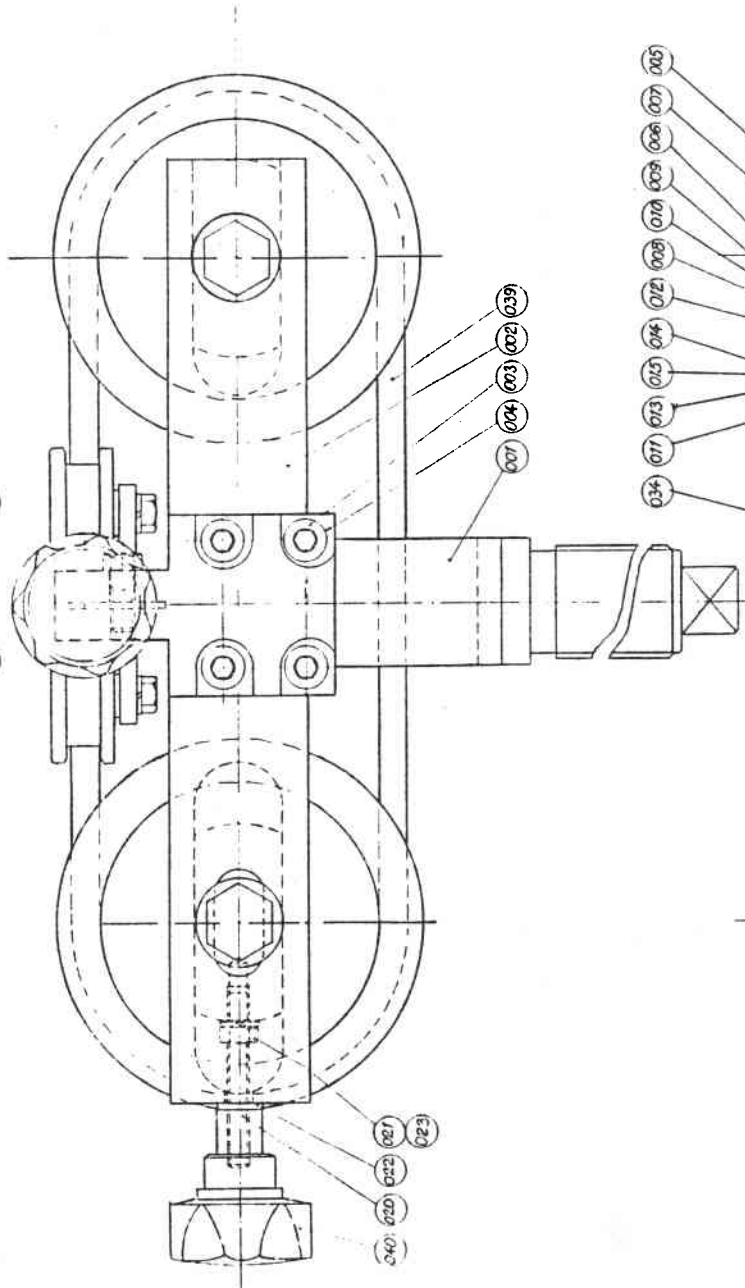
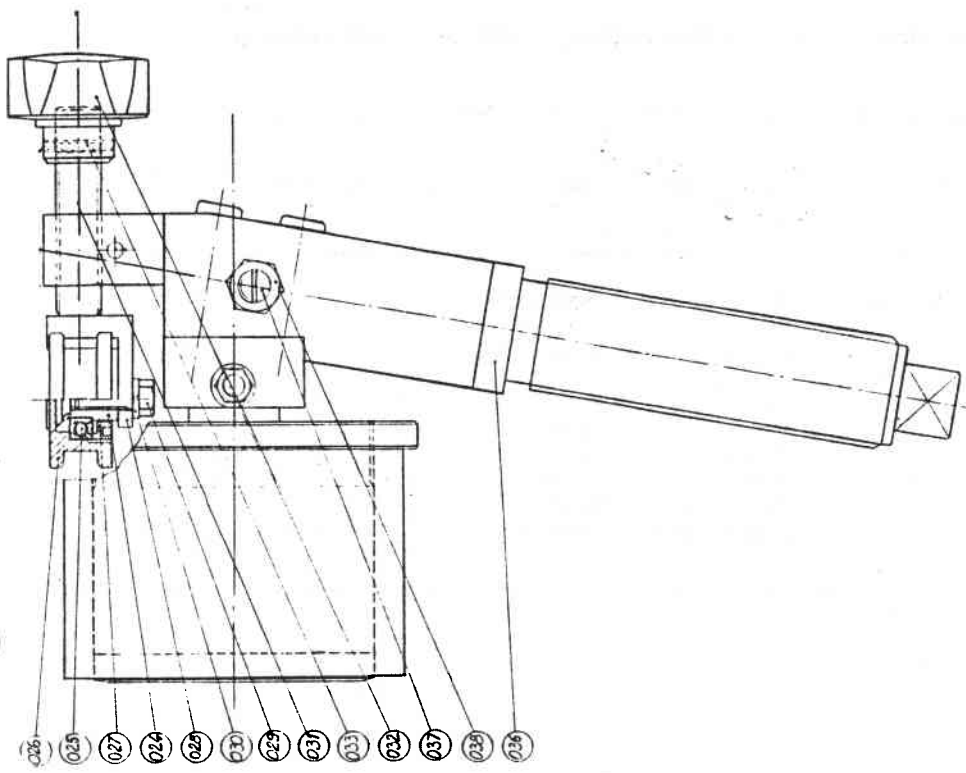
Group -880



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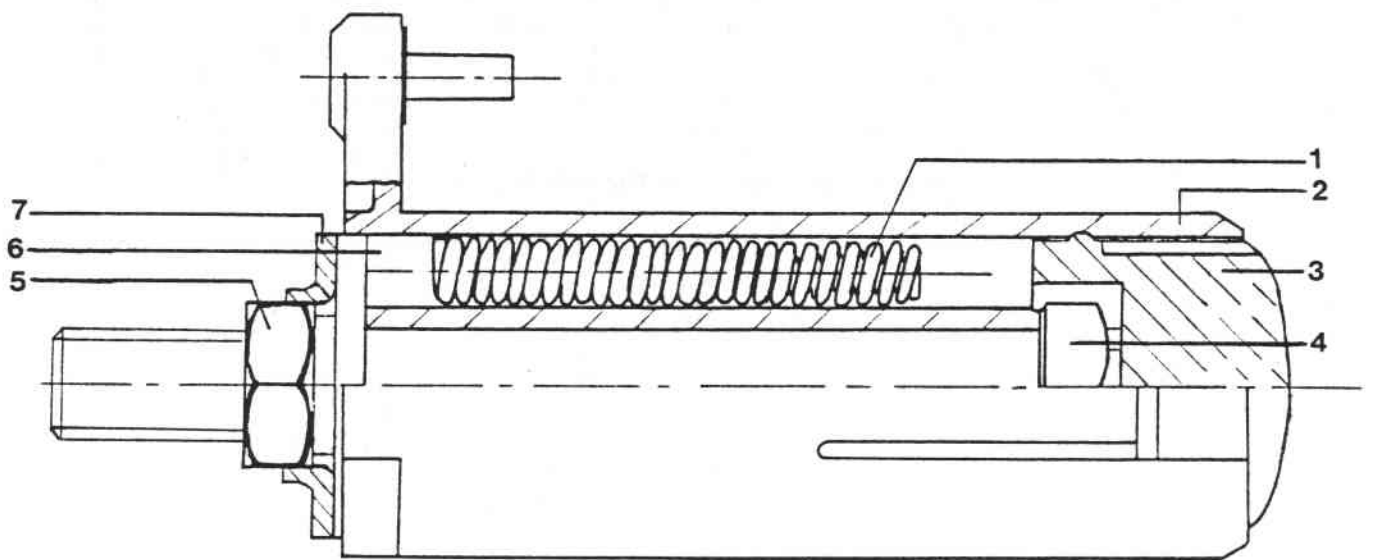
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No.de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|--|------------------------|-------------------------|--------------------------------|-------------------------------|------------------------------------|
| | | 144 850-880 | Pulvertrans- portör | Flux support | Schweiss- pulver- stütze | Transporteur de flux | |
| 001 | 1 | 144 837-001 | Hållare | Holder | Halterung | Support | 10x60 |
| 002 | 1 | 144 838-001 | Platta | Plate | Platte | Plaque | |
| 003 | 4 | 2121 062-73 | Skruv | Screw | Schraube | Vis | |
| 004 | 4 | 2195 010-13 | Fjäderbricka | Spring washer | Federscheibe | Rondelle élastique | |
| 005 | 2 | 144 839-001 | Axel | Shaft | Achse | Arbre | |
| 006 | 4 | 2213 020-38 | Kullager | Ball bearing | Kugellager | Roulement à billes | |
| 007 | 2 | 144 840-001 | Distanshylsa | Spacer sleeve | Zwischenring | Douille entre- toise | |
| 008 | 2 | 144 841-001 | Isolationsring | Insulating ring | Isolerring | Bague d'isolante | |
| 009 | 2 | 2154 012-06 | Låsbricka | Locking washer | Sicherungs- scheibe | Rondelle de blocage | 5x12 |
| 010 | 2 | 2154 013-06 | Rundmutter | Nut | Mutter | Ecrou | |
| 011 | 2 | 144 842-001 | Remskiva | Pulley | Riemenscheibe | Poulie de ren- voi | |
| 012 | 2 | 2157 011-38 | Spårring | Retaining ring | Nutring | Circlips | |
| 013 | 2 | 144 843-001 | Lock | Cover plate | Deckblech | Couvercle | 6x12 |
| 014 | 8 | 2121 062-15 | Skruv | Screw | Schraube | Vis | |
| 015 | 8 | 2195 010-07 | Fjäderbricka | Spring washer | Federscheibe | Rondelle élastique | |
| 016 | 2 | 144 844-001 | Ställring | Setting ring | Einstellring | Bague d'arrêt réglable | |
| 017 | 2 | 2122 043-01 | Stoppskruv | Stop screw | Anschlagsc- hraube | Vis d'arrêt | 8x60 |
| 018 | 2 | 2121 016-50 | Skruv | Screw | Schraube | Vis | 16x30 |
| 019 | 2 | 2151 000-31 | Bricka | Washer | Scheibe | Rondelle | |
| 020 | 1 | 2122 108-11 | Pinnskruv | Stud | Stiftschraube | Goujon | |
| 021 | 1 | 2195 010-11 | Fjäderbricka | Spring washer | Federscheibe | Rondelle élastique | |
| 022 | 1 | 2151 000-18 | Bricka | Washer | Scheibe | Rondelle | M8x20 |
| 023 | 1 | 2126 011-09 | Mutter | Nut | Mutter | Ecrou | |
| 024 | 2 | 144 845-001 | Axel | Shaft | Achse | Arbre | |
| 025 | 2 | 2213 020-34 | Kullager | Ball bearing | Kugellager | Roulement à billes | |
| 026 | 2 | 144 846-001 | Rulle | Roller | Rolle | Galet | |
| 027 | 2 | 144 847-001 | Skruv | Screw | Schraube | Vis | |
| 028 | 1 | 144 848-001 | Hållare | Holder | Halterung | Support | |
| 029 | 2 | 190 437-451 | Skruv | Screw | Schraube | Vis | |
| 030 | 2 | 2195 010-11 | Fjäderbricka | Spring washer | Federscheibe | Rondelle élastique | M8x25 |
| 031 | 1 | 144 849-001 | Skruv | Screw | Schraube | Vis | |
| 032 | 1 | 2188 101-87 | Handratt isole- rad | Insulated hand wheel | Isoliertes Handrad | Volant de com- mande isolé | |
| 033 | 1 | 2111 029-49 | Rörpinne | Roll pin | Spannstift | Goupille élastique | |
| 034 | 1 | 2157 010-07 | Spårring | Retaining ring | Nutring | Circlips | 12x30 |
| 035 | 1 | 2121 062-50 | Skruv | Screw | Schraube | Vis | |
| 036 | 1 | 144 851-001 | Axel | Shaft | Achse | Arbre | |
| 037 | 1 | 2122 037-14 | Stoppskruv | Stop screw | Anschlagsc- hraube | Vis d'arrêt | |
| 038 | 1 | 2126 011-11 | Mutter | Nut | Mutter | Ecrou | |
| 039 | 1 | 0409 795-01 | Transportband | Endless rubber strip | Transportband | Ruban trans- porteur | |
| 040 | 1 | 145 405-880 | Ställratt | Set screw | Einstell- schraube | Vis de réglage | |



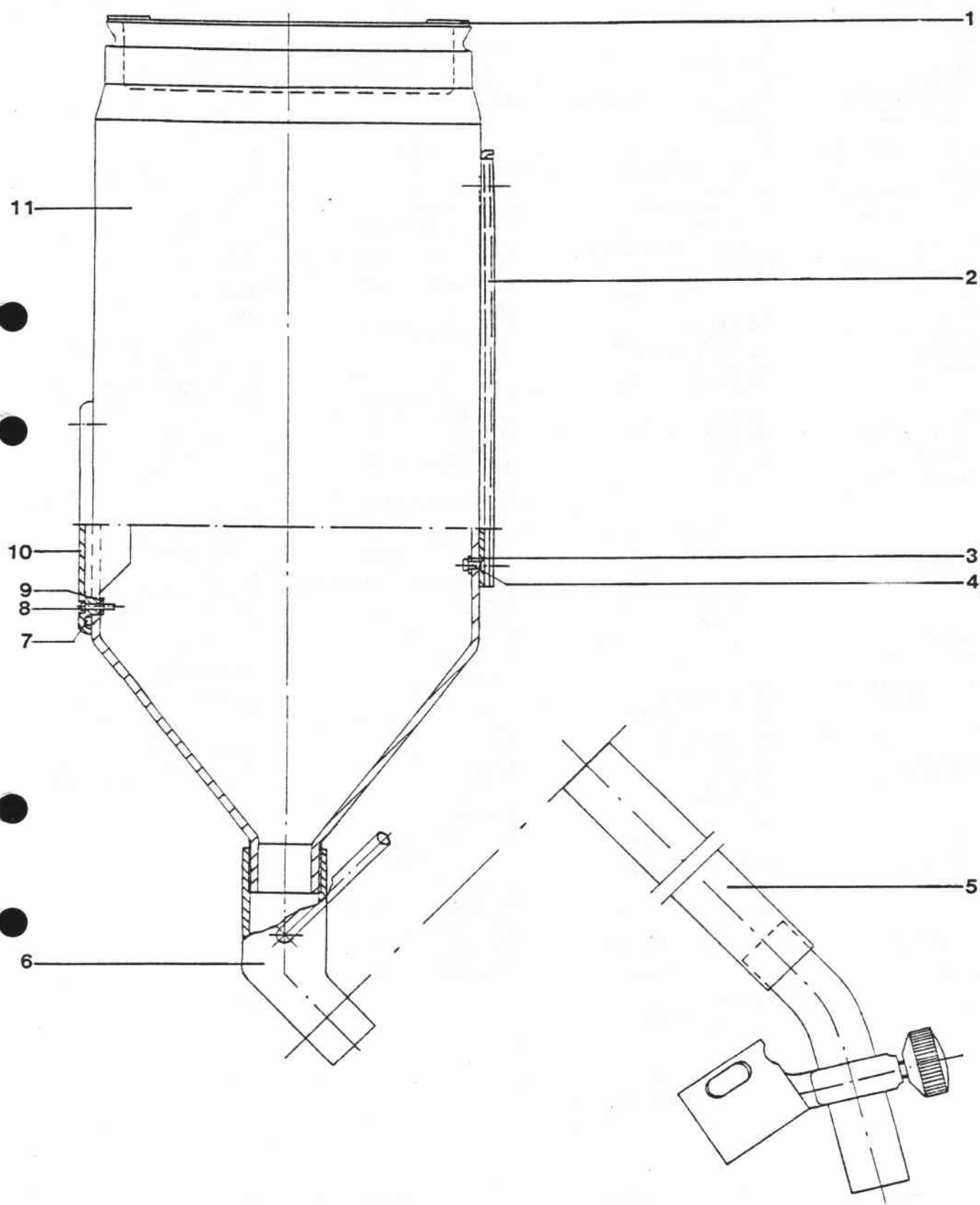
Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

| Pos nr Item no. Pos. Nr. No. de réf. | Ant Qty Anz Qté | Best nr Ordering no. Bestellnr. No. de commande | Benämning | Denomination | Bezeichnung | Désignation | Anm Remarks Anm. Remarque |
|---|--------------------------|---|-------------|-----------------------|--------------|------------------------|------------------------------------|
| | | 146 967-880 | Bromsnav | Brake hub | Bremsnabe | Moyeu-frein | |
| 1 | 2 | 146 969-001 | Tryckfjäder | Compression spring | Druckfeder | Ressort de pression | |
| 2 | 1 | 146 968-880 | Nav | Hub | Nabe | Moyeu | |
| 3 | 1 | 147 315-001 | Spärr | Catch | Sperre | Cliquet | |
| 4 | 1 | 2121 018-66 | Skruv | Screw | Schraube | Vis | M16x140 |
| 5 | 1 | 2126 020-13 | Mutter | Nut | Mutter | Ecrou | M16 |
| 6 | 1 | 146 970-001 | Bromaskiva | Brake disc | Bremsscheibe | Disque de frein | |
| 7 | 1 | 156 617-001 | Bromsbricka | Brake washer | Bremsscheibe | Rondelle de frein | |



Reservdelsförteckning - Spare parts list - Ersatzteilverzeichnis - Liste de pièces détachées

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|---|--------------------------|--|------------------------|--------------------|----------------------|-------------------------|------------------------------------|
| | | 147 649-881 | Pulverbehållare, kompl | Flux hopper, compl | Pulverbehälter, kpl. | Réservoir à flux, compl | |
| 1 | 1 | 0203 017-80 | Pulversil | Flux strainer | Pulversieb | Filtre à flux | |
| 2 | 1 | 147 645-001 | Beslag | Fitting | Beschlag | Garniture | |
| 3 | 4 | 2151 000-10 | Bricka | Washer | Scheibe | Rondelle | D8/4,3x0,8 |
| 4 | 4 | 191 898-108 | Nit | Rivet | Niet | Rivet | |
| 5 | 1 | 145 064-001 | Pulverslang | Flux hose | Pulverschlauch | Tuyau d'amenée de flux | L = 500 |
| 6 | 1 | 153 347-880 | Pulverventil | Flux valve | Pulverventil | Vanne à flux | |
| 7 | 1 | 148 823-001 | Tätning | Seal | Dichtung | Garniture d'étanchéité | |
| 8 | 2 | 2121 080-31 | Skruv | Screw | Schraube | Vis | M3x16 |
| 9 | 2 | 148 799-001 | Bricka | Washer | Scheibe | Rondelle | |
| 10 | 1 | 148 837-001 | Nivåfönster | Inspection window | Standglas | Fenêtre d'inspection | |
| 11 | 1 | 154 007-001 | Behållare för pulver | Hopper for flux | Behälter für Pulver | Réservoir pour flux | |



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